
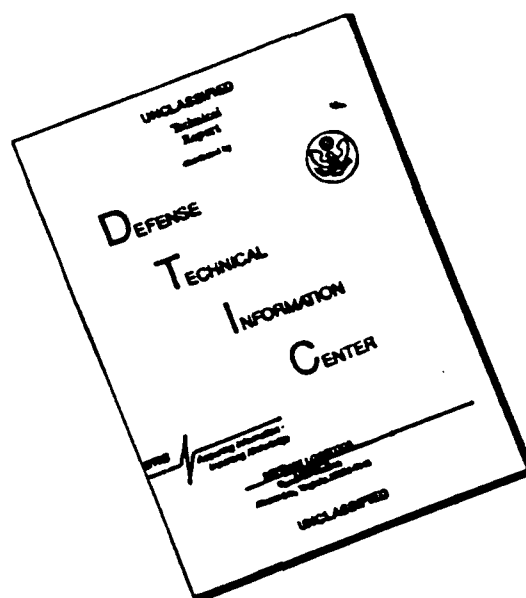


AD-A237 397 		Form Approved OMB No 0704-0188	
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5. FUNDING NUMBERS Contract		6. AUTHOR(S) McDonnell Douglas Missile Systems Company	
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91-02797

MAN PGW

BRAKES.

Profile Sheets.

OPERATION PROFILE

13-52 CARRIER ASSY (MAG)

NAME D. DIVELEBISS ALC 00 DATE 5 JUN 89 RCC DTANPGW SHEET 1 OF 6

WCD 16201N WCD DATE 890628

PCN 156008A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
5A	MTAN PGW	REM	1.000	TRANSIT							STATOR OR. SLEEVE
				SETUP							
				PROCESS							
5B	MTAN PGW	REM	1.000	TRANSIT							Piston Assy
				SETUP							
				PROCESS							
5C	MTAN PGW	REM	1.000	TRANSIT							Torque Pin
				SETUP							
				PROCESS							
5D	MTAN PGW	REM	1.000	TRANSIT							BLEEDER SCREW ASSY
				SETUP							
				PROCESS							
5E	MTAN PGW	LOAD	1.000	TRANSIT							QH Conveyor
				SETUP							
				PROCESS							

T.O. 401-4-133

1.5C-200000

OPERATION PROFILE

3-52 CARRIER ASSY

NAME D. DIVELOISS ALC 00 DATE 5 JUL 83 RCC MANREGW SHEET 3 OF 6

WCD 16201N WCD DATE 890608															
WCD 15608A															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS		
					SKILL CODE/LEVEL	QTY.	%	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.					
7	MAN PEW	CLN	1.00	TRANSIT								100	3.47	CHURN CLEAN MAG. LINE	
				SETUP											
				PROCESS											
7A 8A	MAN PEW	LNU	1.00	TRANSIT								100	3.47	ALT'S. 0630 0630 0.4. CONV.	
				SETUP											
				PROCESS											
9	MAN PEW	CLN	1.00	TRANSIT								100	.02	BLAST-BEAD	
				SETUP											
				PROCESS											
9A 9B	MAN PEW	LOAD	1.00	TRANSIT								100	.02	ALT. 0412 O.H. CONV.	
				SETUP											
				PROCESS											
10	MAN PEW	CLN	1.00	TRANSIT								100	3.47	MAG. CLN. ALT'S. 0630 0630	
				SETUP											
				PROCESS											

OPERATION PROFILE

13-52 CARRIER ASSY

NAME D. DINGELISS ALC 00 DATE 5 JUL 89 RCC MTANBGM SHEET 3 OF 6

WCD 16201 N WCD DATE 890608

PCN 156000

156000																				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS									
					MANDATORY FLOW HOURS	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.		TIME REQUIRED								
					%	HRS.		%	HRS.		%	HRS.								
20A	MAN PGW	BROD	1.00	TRANSIT										Nick & Buen						
				SETUP																
				PROCESS						1	100	.02	1		100	.02				
20	MAN PGW	Proc.	1.00	TRANSIT										ALT. PMOY11 Roller Conv.						
				SETUP																
				PROCESS									1		100	.60	1	100		
20B	MAN PGW	Load	1.00	TRANSIT																
				SETUP																
				PROCESS												1	100	.02	1	100
30	MAN PGW	Insp	1.00	TRANSIT										E & I						
				SETUP																
				PROCESS														1	100	.08
30A	MAN PGW	Stack	1.00	TRANSIT										Paller & Paperwork						
				SETUP																
				PROCESS																

O/LA Conv.

Nick & Bueh

ALT. PMOY11
Roller Conv.

E & I

Pallet & Paperwork

OPERATION PROFILE

B-52 CARRIER ASSY

NAME D. DIVELOISS ALC 00 DATE 5 JUN 89 RCC MTANPGW SHEET. 4 OF 6

PCN NSN			WCD 16201N			WCD DATE 89068			WCD 16201N			WCD DATE 89068			WCD 16201N			WCD DATE 89068		
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS					
					%	HRS.			%	HRS.			%	HRS.						
122A	MTAN PGW	LOAD	1.00	TRANSIT											0.4. Conveyor					
				SETUP																
				PROCESS			KIOS	1	100	.02	100	.02								
122	MTAN PGW	Proc	1.00	TRANSIT							P1109901	1	100	1.26	Dow #7 TREATMENT					
				SETUP			KIOS	1	100	.05										
				PROCESS	100	1.05					100	1.26								
122G	MTAN PGW	UNLD	1.00	TRANSIT							100001	1	100	1.26	Off. Conveyor					
				SETUP																
				PROCESS																
127A	MTAN PGW	LOAD	1.00	TRANSIT							P1109901	1	100	1.02	0.4. Conveyor					
				SETUP																
				PROCESS			KIOS	1	100	.02	100	.02								
127	MTAN PGW	Proc	1.00	TRANSIT							P1109901	1	100	1.02	Dow #7 TREATMENT					
				SETUP																
				PROCESS	100	1.05					100	.05								

OPERATION PROFILE

13-52 CARRIER ASSY (MAG)

NAME D. DINELISS ALC 00 DATE 5 JUN 89 RCC MTANPSW SHEET 5 OF 6

WCD 16201 N WCD DATE 89068

PCN 15608A

NSN 15608A

PN 15608A

MSN
PIN

156008A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		TIME REQUIRED		EQUIPMENT		DATA SOURCE COMMENTS	
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
127B	MAN PSW	UNLO	1.00	TRANSIT										O.H. Conv.	
				SETUP											
				PROCESS			KIOS	1	100	.02	PM0001	1	100		.02
153A	MAN PSW	LOAD	1.00	TRANSIT										O.H. Conv.	
				SETUP											
				PROCESS			KIOS	1	100	.02	PM0001	1	100		.02
153	MAN PSW	PROC	1.00	TRANSIT										MAG-Strip	
				SETUP											
				PROCESS	100	.50	KIOS	1	100	.05					.72
153B	MAN PSW	UNLO	1.00	TRANSIT										O.H. Conv.	
				SETUP											
				PROCESS			KIOS	1	100	.02	PM0001	1	100		.02
160A	MAN PSW	LOAD	1.00	TRANSIT										O.H. Conv.	
				SETUP											
				PROCESS			KIOS	1	100	.02	PM0001	1	100		.02

OPERATION PROFILE

B-52 CARRIER ASSY (MAG)

NAME D. DUEBELGESS ALC SO DATE 5 JUN 89 RCC MANPSW SHEET 6 OF 6

WCD 16201N WCD DATE 89068

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS		
					%	HRS.			%	HRS.			%	HRS.			
160	MAN PSW	Proc	1.00	TRANSIT											DOW #7 TREATMENT		
				SETUP			KIDS	1	100.05								
				PROCESS	100	1.05											
160B	MAN PSW	UNLO	1.00	TRANSIT											O.H. Conv.		
				SETUP													
				PROCESS			KIDS	1	100.02								
				TRANSIT													
				SETUP													
				PROCESS													
				TRANSIT													
				SETUP													
				PROCESS													
				TRANSIT													
				SETUP													
				PROCESS													

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

WCD 16201N WCD DATE 89068

ECN 15068A

15068A																					
NSN PM	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS							
						%	HRS.	QTY.	%	HRS.	QTY.	%	HRS.		EQUIPMENT CODE	QTY.	%	HRS.			
15	MAN PNA	FPI	.75		TRANSIT																
					SETUP																
					PROCESS																
					TRANSIT																
15A	MAN PNA	FPI	.25		TRANSIT																
					PROCESS																
					PROCESS																
					PROCESS																
15B	MAN PGW	UNLD	1.0		TRANSIT																
					PROCESS																
					PROCESS																
					PROCESS																

Completed 160118

South

OPERATION PROFILE

NAME S. Crawford ALO 90 DATE 5-26-89 RCC MAN PWS SHEET OF

WCD 16201N WCD DATE 89068

NSN PIN 15068A

NSN 15068A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE		QTY.	%	HRS.
40	MAN PWS	LOAD OVEN	1	TRANSIT									LOAD OVEN HEAT UNLOAD OVEN		
				SETUP											
				PROCESS	1.0	1.7	WL 10	1	1.0	1.2	GW 21 4191	1		1.0	1.7
40A	MAN PWS	WELD	1	TRANSIT									WELD INLET PIPES.		
				SETUP											
				PROCESS			WL 10	1	1.0	1.0	PM 6276	1		1.0	1.7
50	MAN PWS	LOAD OVEN	1	TRANSIT									LOAD OVEN HEAT UNLOAD OVEN		
				SETUP											
				PROCESS	1.0	1.7	WL 10	1	1.0	1.2	GW 21 4191	1		1.0	1.7
50A	MAN PWS	WELD	1	TRANSIT									WELD CROSS OVEN POINT.		
				SETUP											
				PROCESS							PM 6276	1		1.0	1.7
60	MAN PWS	LOAD OVEN	1	TRANSIT									LOAD OVEN HEAT UNLOAD OVEN		
				SETUP											
				PROCESS	1.0	1.7	WL 10	1	1.0	1.2	GW 21 4191	1		1.0	1.7

15068A

OPERATION PROFILE

NAME C. Crawford ALO 00 DATE 5-26-89 RCC MAIS PWW SHEET OF

WCD 1620110 WCD DATE 890618

PCN 15068A

PN 15068A																
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.	
60A	WLD PWW	WELD	1	TRANSIT										WELD BLESSOR PORT		
				SETUP												
				PROCESS												
60B	WLD PWW	OVERT	1	TRANSIT										POST HEAT PART STRESS RELIEF		
				SETUP												
				PROCESS	1.0	1.7	WLD	1	1.0	1.0	PM 6276	1	1.0		1.7	
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

OPERATIONAL PROFILE

NAME Turner ALC 00 DATE 5-24-89 RCC MANPRA SHEET 1 OF 2

PCN NSN PIN		15068A		WCD 16201N		WCD DATE 89068		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED				
					%	HRS.			%	HRS.			%	HRS.			
65	MAN	Repe	.50	TRANSIT			JA 10	1		.02							
	SETUP					JA 10	1		.56	PM 2577	1		.56				
	PROCESS					JA 10	1		.49	PM 2577	1		.49				
70	MAN	Dril	.50	TRANSIT			JA	1		.02							
	SETUP					JA 10	1		.56	PM 2577	1		.56				
	PROCESS					JA 10	1		.49	PM 2577	1		.49				
80	MAN	Dril	.50	TRANSIT			JA 10	1		.02							
	SETUP					JA 10	1		.56	PM 2577	1		.56				
	PROCESS					JA 10	1		.49	PM 2577	1		.49				
120	MAN	Repe	.10	TRANSIT			JA 10	1		.02							
	SETUP					JA 10	1		.56	PM 7211	1		.56				
	PROCESS					JA 10	1		.49	PM 7211	1		.49				
125	MAN	Rezm	.10	TRANSIT			JA 09	1		.02							
	SETUP					JA 09	1		.56	PM 2577	1		.56				
	PROCESS					JA 09	1		.49	PM 2577	1		.49				

OPERATIONAL PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 of 2

PCN NSN PIN			WCD			WCD DATE			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS		
								%	HRS.			%	HRS.			
130	MAN PRA	Heli	1.00	TRANSIT		IA 08	1		.02					Bench OP		
				SETUP		IA 08	1		.31							
				PROCESS		IA 08	1		.35							
140	MAN PRA	Heli	1.00	TRANSIT		IA 08	1							Bench OP		
				SETUP		IA 08	1		.31							
				PROCESS		IA 08	1		.35							
150	MAN PRA	Heli	1.00	TRANSIT		IA 08	1		.02					Bench OP		
				SETUP		IA 08	1		.31							
				PROCESS		IA 08	1		.35							
152	MAN PRA	Dril	.50	TRANSIT		IA 10	1		.02							
				SETUP		IA 10	1		.56	PM 2577	1		.56			
				PROCESS		IA 10	1		.46	PM 2577	1		.46			
175	MAN PRA	Inst.	.50	TRANSIT		IA 09	1		.02					Bench OP		
				SETUP		IA 09	1		.18							
				PROCESS		IA 09	1		.17							

OPERATION PROFILE

Boles

NAME Kyle Kerdin ALC 00 DATE 5-16-89 RCC MANREP-14242 SHEET 1 OF 5

PCN		WCD		WCD DATE		EQUIPMENT		MANPOWER		TIME REQUIRED		DATA SOURCE		
NSN	PIN	15068A	16201N	89068										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.	COMMENTS
170	PLP	LOAD	1.00	TRANSIT										Typed check paper
				SETUP										LOAD, 5 weeks
				PROCESS		Y409	1		.1	PM032	1		.1	per load
														9 brakes/load
170A		CIN		TRANSIT										Perchloroethane
				SETUP										degrease
				PROCESS	.8	Y409	1		.5	PM033	1		.5	cool (5 min)
170B		LOAD		TRANSIT										LOAD In
				SETUP										impregnation
				PROCESS		Y409	1		.6	PM1342	1		.6	Draw Vac.
170C		POC		TRANSIT										Draw In
				SETUP										resin,
				PROCESS	1.5	Y409	1		.1	PM1342	1		.15	Resinize
170D		Draw		TRANSIT										Unload
				SETUP										
				PROCESS		Y409	1		.1	PM1342	1		.1	

WCD DATE 89068

WCD 16201N

PCN 15068A

B-52 Housing

Desun Impress

15C-2042X

OPERATION PROFILE

Baker

SHEET 2 OF 5

DATE 5-17-89

ALC 00

NAME Kyle K

WCD DATE

WCD

15068A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.			%	HRS.	
170E	RGP	CN	1.000	TRANSIT			Y609	1		.1	Pm6013	1		.1	Weight & process
				SETUP							Pm6014	1		.1	
				PROCESS											
170F		Cure	1.000	TRANSIT											Cure in Hot oil
				SETUP											
				PROCESS		1.3	Y609	1		.1	C10001	1		1.3	
170G		CN	1.000	TRANSIT		3	Y609	1		.1	Pm6012	1		.1	Hot Rinse & Millstone cleaning
				SETUP							Pm6013	1		.2	
				PROCESS											
170H		CN	1.000	TRANSIT											Clean Bore & threads in Housing Cylinder holes
				SETUP											
				PROCESS			Y609	1		.1					
				TRANSIT											
				SETUP											
				PROCESS											

B-52 Housing
Design Improv

OPERATION PROFILE

NAME ALC 00 DATE 5-20-89 RCC brakes SHEET 3 OF 55

WCD 16201N WCD DATE 890608

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					% HRS.		% HRS.			% HRS.	
180	MAN 96P	INFL	1.0	TRANSIT SETUP PROCESS		1	.01	FLOOD1	1	.01	Inspect part check paper
190	MAN 96P	LOAD	1.0	TRANSIT SETUP PROCESS		1	.05	PM0932	1	.05	Load on Paint conveyor
190A	MAN 96P	WASH	1.0	TRANSIT SETUP PROCESS		1	.01	PM0922	1	.01	solvent wash
190B	MAN 96P	plug	1.0	TRANSIT SETUP PROCESS		1	.08	PM0922	1	.08	Extensive plugging's
190C	MAN 96P	Prune	1.0	TRANSIT SETUP PROCESS		1	.03	PM0922	1	.03	Prune 2 coals and dry time

B-52 Housing

Dr

OPERATION PROFILE

NAME <u>Verstappen</u>		ALC		DATE		RCC		SHEET <u>4</u> OF <u>45</u>		
WCD <u>15068A</u>		WCD <u>16201A</u>		WCD DATE <u>SPAD</u>						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	QTY.	
190D	96P	Plus	1.0	TRANSIT						Additional plugging
				SETUP						
				PROCESS						
190E		Pin	1.0	TRANSIT						1st Coat
				SETUP						
				PROCESS						
190F		Pin	1.0	TRANSIT						2nd Coat and Dry
				SETUP	5					
				PROCESS						
190G		UNLD	1.0	TRANSIT						UNLOAD & Strip
				SETUP						
				PROCESS						
190H		Rep	1.0	TRANSIT						Disarm Clean ERT of Pistons & Cylinders 12 each
				SETUP						
				PROCESS						

B-52 Housing

OPERATION PROFILE

NAME <u>Kerstan</u>		ALC		DATE		RCC		SHEET <u>5</u> OF <u>5</u>					
PCN <u>15068A</u>		WCU <u>162011</u>		WCD DATE <u>89060</u>									
NSN <u>15068A</u>		MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS					
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	QTY.	%	HRS.
245	PAP	Appt	1.0	TRANSIT									
				SETUP									
				PROCESS			Y609	1		.02			
				TRANSIT									
260	PAP	Insp	1.0	SETUP									
				PROCESS			Y609	1		.02			
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

Acceptance of paperwork

Final Visual Inspect.

OPERATION PROFILE

13-52 PRESSURE PLATE ASSY (STEEL)

NAME D. DIVELEISS ALC 00 DATE 6 JUN 89 RCC MTAN PGW SHEET 1 OF 2

WCD 16202N																
WCD DATE 89040																
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS					
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.		
5	MAN PGW	DIS	1.00	TRANSIT										REM. ADJ. PAN - SEP. Press Pl.		
				SETUP												
				PROCESS												
5A	MAN PGW	STACK	1.00	TRANSIT										on Pailer BOARD		
				SETUP												
				PROCESS												
7	MAN PGW	REM	1.00	TRANSIT										LINEAL		
				SETUP												
				PROCESS												
7A	MAN PGW	STACK	1.00	TRANSIT										A/C - PM0430 ON Pailer		
				SETUP												
				PROCESS												
8A 76	MAN PGW	LOAD	1.00	TRANSIT										POTOMAST MEAT HOOKS		
				SETUP												
				PROCESS												

TO 401-4-133

OPERATION PROFILE

B-52 PRESSURE PLATE ASSY

SHEET 2 OF 2

NAME: D. DIVELEISS ALC

DATE 6 JUN 83

RCC MANAGER

WCD DATE 8 DEC 80

WCD 16202N

15068A

OPERATION NUMBER		RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT			DATA SOURCE COMMENTS	
PM	PM					%	HRS.			%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
8	MAN PGW	CLN	1.000	TRANSIT											Roto Blast	
				SETUP												
				PROCESS												
8G	MAN PGW	LNLD	1.000	TRANSIT											Roto Blast to Pallet	
				SETUP												
				PROCESS												
8C	OVHD	MOVE	1.000	TRANSIT											From DIS TO 6FI	
				SETUP												
				PROCESS												
10	MAN PGW	INSP	1.000	TRANSIT											E & I	
				SETUP												
				PROCESS												
10A	MAN PGW	STACH	1.000	TRANSIT											On Pallet & Paper - worn	
				SETUP												
				PROCESS												

OPERATION PROFILE

NAME MEL ANDERSON ALIC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 3

PCN 15068A
NSN
PM

WCD 16202N

WCD DATE 89040

15068A															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.		SKILL CODE/ LEVEL	QTY.	%	HRS.		EQUIPMENT CODE		QTY.
				TRANSIT											
				SETUP											
				PROCESS											
20	MAN PNA	MAG	1.0	TRANSIT											
				SETUP											
				PROCESS											
20A	MAN PNA	DEGR	1.0	TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
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				TRANSIT											

OPERATIONAL PROFILE

NAME MEL ANDERSON/ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 2

WCD 162031N WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
				TRANSIT												
				SETUP												
				PROCESS												
30	MAN PNA	MAG	1.0	TRANSIT			OVHD	1		.10	FL 0002	1		.10		
				PROCESS			DB09	1		.10	PM 6668	1		.10		
30A	MAN PNA	DEGR	1.0													
				PROCESS			DB09	1		.07	PM 3428	1		.07		
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

13315

NAME C. C. GORDON ALG 00 DATE 6-30-89 RCC MAN (P.W.U.) SHEET OF

WCD 1620220
WCD DATE 89040

PCW

MSN
P/N 15068A

NSM PN 150 B2A														
OPERATION NUMBER	RCG	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
					%	HRS.	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.
25	MAN PWW	LOAD	1	TRANSIT								Load on Rack 4 Place in Furnace 10/6/68 20/LOAD		
				SETUP										
				PROCESS										
25A	MAN PWW	Bake	1	TRANSIT								HEAT UP IN OVEN		
				SETUP										
				PROCESS										
25B	MAN PWW	UNLOAD	1	TRANSIT								REMOVE FROM OVEN		
				SETUP										
				PROCESS										
25C	MAN PWW	COOL DOWN		TRANSIT								AIR COOL DOWN		
				SETUP										
				PROCESS	1.0	6.0								
25D	MAN PWW	UNLOAD	1	TRANSIT								REMOVE FROM RACK BY HAND		
				SETUP										
				PROCESS										

2.5"1

OPERATION PROFILE

NAME Turner ALC 00 DATE 5-24-89 RCC MAN PRA SHEET 1 OF 1

PCN		NSN		PIN		WCD		WCD DATE		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS								
OPERATION NUMBER		RCC		OPERATION DESCRIPTION		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE		MANDATORY FLOW HOURS		SKILL CODE/LEVEL		QTY.		TIME REQUIRED		QTY.		TIME REQUIRED		DATA SOURCE COMMENTS		
28	MAN			Ream	1.00	TRANSIT					JA 10	1												
	PRA					SETUP					JA 10	1												
							PROCESS					JA 10	1											
						TRANSIT																		
						SETUP																		
						PROCESS																		
						TRANSIT																		
						SETUP																		
						PROCESS																		
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						SETUP																		
						PROCESS																		
						TRANSIT																		
						SETUP																		
						PROCESS																		
						TRANSIT																		
						SETUP																		
						PROCESS																		

OPERATION PROFILE

NAME Kerstan ALC DATE 5-25-89 RCC Brakes SHEET 1 OF 2

WCD 1620Z WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	QTY.		TIME REQUIRED %	TIME REQUIRED HRS.	
035	MAN REP	TRSP	1.0	TRANSIT		0VHD	1					Transport and inspect and load onto painting line		
				SETUP										
				PROCESS										
040		PRIM	1.0	TRANSIT								PRIME and DRY		
				SETUP		3009	1							
				PROCESS										
040A		PRIM	1.0	TRANSIT								1st coat		
				SETUP		3009	1							
				PROCESS										
040B		PRIM		TRANSIT								2nd coat		
				SETUP		3009	1							
				PROCESS										
040C		PRIM		TRANSIT								unload		
				SETUP		Y609	1							
				PROCESS										

B-52 pressure plate

DR

OPERATION PROFILE

NAME <u>W. E. H. H. H.</u>		ALC _____		DATE _____		RCC _____		SHEET <u>2</u> OF <u>2</u>	
WCD <u>162022N</u>		WCD DATE <u>090416</u>		WCD DATE <u>090416</u>		WCD DATE <u>090416</u>		WCD DATE <u>090416</u>	
P/N <u>15068A</u>		P/N <u>15068A</u>		P/N <u>15068A</u>		P/N <u>15068A</u>		P/N <u>15068A</u>	
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER	EQUIPMENT	TIME REQUIRED	DATA SOURCE COMMENTS
					%	QTY.	EQUIPMENT CODE	%	
050	MAN PGP	Rivet	1.0	TRANSIT					Rivet friction elements
				SETUP					
				PROCESS					
060	{	Insp	1.0	TRANSIT					Inspect paperwork
				SETUP					
				PROCESS					
				TRANSIT					
				SETUP					
				PROCESS					
				TRANSIT					
				SETUP					
				PROCESS					
				TRANSIT					
				SETUP					
				PROCESS					
				TRANSIT					
				SETUP					
				PROCESS					

B-52 pressure plad

OPERATION PROFILE

B-52 STATION ASSY (STEEL)

NAME P. DINGELISS ALC 00 DATE 6 JUN 85 RCC MANPSW SHEET 1 OF 2

PCN INH PN 15068A WCD 16203N WCD DATE 89040															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.	
5	MAN PSW	DIS	1.00	TRANSIT									SEP. STATIONS FROM ROTORS		
				SETUP											
				PROCESS											
6	MAN PSW	REM	1.00	TRANSIT									LINERS		
				SETUP											
				PROCESS											
6A	MAN PSW	STOCK	1.00	TRANSIT									ALL PMOY430 ON PALLET		
				SETUP											
				PROCESS											
6B	MAN PSW	LOAD	1.00	TRANSIT									ROTOR BLAST MEAT HOOKS		
				SETUP											
				PROCESS											
6C	MAN PSW	C/W	1.00	TRANSIT									ROTOR BLAST		
				SETUP											
				PROCESS											

WCD 162033N WCD DATE 89040

15068A

401-4-133

DR

OPERATION PROFILE

B-52 STATION ASSY

NAME D. DUBUIS ALC 00 DATE 6 JUN 89 RCC MAN PGW SHEET 2 OF 2

WCD 16203N WCD DATE 85040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS		QTY.	%	HRS	EQUIPMENT CODE	QTY.	%	HRS		
8A	MAN PGW	UNLO	1.00	TRANSIT												ROTORCAST TO Pallet
				SETUP												
				PROCESS												
12	MAN PGW	Insp	1.00	TRANSIT												E&I
				SETUP												
				PROCESS												
12A	MAN PGW	Stack	1.00	TRANSIT												on Pallet + Paperwork
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

OPERATIONAL PROFILE

NAME <u>MEL ANDERSON ALC</u> OO <u>00</u> DATE <u>5-31-89</u> RCC <u>MANPGW</u> SHEET <u>1</u> OF <u>3</u>												
WCD <u>16203A</u>		WCD DATE <u>89040</u>										
WCD <u>15068A</u>		WCD DATE <u>89040</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE		QTY.
				TRANSIT								
				SETUP								
				PROCESS								
20	MAN PNA	MAG	1.0	TRANSIT								
				SETUP								
				PROCESS								
20A	MAN PNA	DEGR	1.0	TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

CONFIDENTIAL 16-2052d

OPERA PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 2

WCD 16203N WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED %	QTY.	
				TRANSIT	%						
				SETUP	MRS.						
				PROCESS							
30	MAN PNA	MAG	1.0	TRANSIT		OVHD	1			FL 0002	
				PROCESS		DB09	1			PM 6668	
30A	MAN PNA	DEGR	1.0	PROCESS		DB09	1			PM 3428	
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

NSN 15068A			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS							
OPERATION NUMBER	ACC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.				%	HRS.			%	HRS.	
25	MAN POW	LOAD	1	TRANSIT											Load in Stack 4 Place in Furnace IS/STACK 30/LOAD	
				SETUP												
				PROCESS												
25A	MAN POW	Bake	1	TRANSIT											HEAT 4W IN OVEN	
				SETUP												
				PROCESS												
25B	MAN POW	UNLOAD	1	TRANSIT											REMOVE FROM OVEN	
				SETUP												
				PROCESS												
25C	MAN POW	COOL DOWN	1	TRANSIT											AIR COOL DOWN	
				SETUP												
				PROCESS	1.0	6.0										
25D	MAN POW	UNLOAD	1	TRANSIT											REMOVE FROM Rack By HAND	
				SETUP												
				PROCESS												

OPERATIONAL PROFILE

NAME Turner ALC 00 DATE 5-24 RCC MANPRA SHEET 1 OF 1

PCH
NSN
PIN

15068A

WCD 16203N

WCD DATE 87040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.	
27	MAN	Room	.10	TRANSIT	JA 10	1		.02					
	PRA			SETUP	JA 10	1		.03	PM 1788	1		.03	
				PROCESS	JA 10	1		.15	PM 1788	1		.15	
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

OR

OPERATION PROFILE

NAME KEESTHAN ALC _____ DATE _____ RCC _____ SHEET 1 OF 1

WCD 16203N WCD DATE 29/10/40

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					SKILL CODE/LEVEL	QTY.	%	TIME REQUIRED	EQUIPMENT CODE	QTY.	%	HRS.	
03h	MAN PAP	Insp	1.0	TRANSIT	0409	1		.01	F10001	1		.01	Inspect and load paint line
				SETUP									
				PROCESS	3409	1		.02	Pm0922	1		.02	
04D		Prim	1.0	TRANSIT									Prime and Dry
				SETUP	3409	1		.01	Pm0922	1		.25	
				PROCESS					Pm0438	1		.01	
04D P		UNLD	1.0	TRANSIT									UNLOAD Grout line painting to conveyor
				SETUP	Y409	1		.01	Pm0922	1		.01	
				PROCESS					Pm0928	1		.01	
050		Rivd	1.0	TRANSIT									Rivd friction elements
				SETUP									
				PROCESS	Y409	1		.07	R20001	1		.07	
060		Insp + Acpt	1.0	TRANSIT									Acceptance of paperwork
				SETUP									
				PROCESS	Y409	1		.02					

B-52 Author Insp 1.0 Process 1.0 .02 Usual Final Inspection

DR

OPERATION PROFILE

B-52 BACKING PLATE (STEEL)

NAME D. DIVELEISS ALC 00 DATE 6 JUN 89 RCC MANDEW SHEET 1 OF 3

WCD 16204N WCD DATE 890400

PCN 15068A

PM 15068A																
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.		
5	MAN RAW	DIS	1.00	TRANSIT											Rem Bolts, WASHERS & NUTS.	
				SETUP												
				PROCESS												
7	MAN RAW	REM	1.00	TRANSIT											LINERS	
				SETUP												
				PROCESS												
7A	MAN RAW	STACK	1.00	TRANSIT											ATT. PMOYD on Pallet	
				SETUP												
				PROCESS												
7B 8A	MAN RAW	LOAD	1.00	TRANSIT											RORO CRANE near Hooks	
				SETUP												
				PROCESS												
8	MAN RAW	CLN	1.00	TRANSIT											RORO CRANE	
				SETUP												
				PROCESS												
					100	.08							PM3452	1	100	.08

T.O. 481-4-133

15C-211W2C

OPERATION PROFILE

13-52 Backing Plate

NAME D. DUNLAP ALC 00 DATE 6 Jul 89 RCC MTAN PGW SHEET 2 OF 2

PCN NSN PIN			WCD _____ WCD DATE _____												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
					MANDATORY FLOW HOURS %	Skill CODE/ LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.	
8B	MTAN PGW	LNLO	1.00	TRANSIT										REQUEST TO Pallet	
				SETUP											
				PROCESS		4305	1	100	.01	PM7432	1	50	.01		
12	MTAN PGW	INSP	1.00	TRANSIT										E&I	
				SETUP											
				PROCESS		DI	1	100	.08	FP0001	1	100	.08		
12A	MTAN PGW	STACK	1.00	TRANSIT										Palletize	
				SETUP											
				PROCESS		DI	1	100	.02						
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATIONAL PROFILE

[illegible]

OPERAT. PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 2

WCD 16205N WCD DATE 89040

PCID
NSH
P/N 15068A

PM / 5068A																	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.		SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.	
				TRANSIT													
				SETUP													
				PROCESS													
30	MAN PNA	MAG	1.0	TRANSIT				OVHD	1		.10	FL 0002	1		.10		
				PROCESS				DB09	1		.10	PM 6668	1		.10		
30A	MAN PNA	DEGR	1.0														
				PROCESS				DB09	1		.07	PM 3428	1		.07		
				TRANSIT													
				SETUP													
				PROCESS													
				TRANSIT													
				SETUP													
				PROCESS													

OPERATION PROFILE

B 62

STEEL

NAME CIRCUIT ALG 00 DATE 5-30-89 RCG MAN/PWW SHEET OF

PCN		NSN		PIN		15068A		WCD 16204 N		WCD DATE 89040		EQUIPMENT		DATA SOURCE COMMENTS		
OPERATION NUMBER	ROG	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	HRS.	QTY.	TIME REQUIRED %	HRS.
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE					
25	MAN PWW	LOAD	1	TRANSIT			WFOB WFOB									Load on Rack 1 Place in Furnace 10/Stack 20/LOAD
				SETUP												
				PROCESS					2	1.0	.3	CE 24	1	1.0	.3	
25A	MAN PWW	Bake	1	TRANSIT												HEAT UP IN OVEN
				SETUP												
				PROCESS												
25B	MAN PWW	UNLOAD	1	TRANSIT												REMOVE FROM OVEN
				SETUP												
				PROCESS					2	1.0	.3	CE 24	1	1.0	.3	
25C	MAN PWW	COOL DOWN		TRANSIT												AIR COOL DOWN
				SETUP												
				PROCESS	1.0	6.0										
25D	MAN PWW	UNLOAD	1	TRANSIT			WFOB WFOB									REMOVE FROM Rack By hand
				SETUP												
				PROCESS					2	1.0	.3	CE 24	1	1.0	.3	
										</						

OPERATION PROFILE

NAME Turner ALC AL DATE 5-24-89 RCC MAN PRA SHEET 1 OF 1

PCN
NSN
PIN

WCD 16204N WCD DATE 89040

15068A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	
27	MAN	Recm	1.00	TRANSIT	JA 10	1	.02				
	PRA			SETUP	JA 10	1	.56	PM 2576	1	.56	
				PROCESS	JA 10	1	.46	PM 2576	1	.46	
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

30 EMP

ISC-200020

OPERATION PROFILE

NAME KERSTMAN ALC 80 DATE 16204N RCC Drakes SHEET 1 OF 2

NSN 15069A WCD 16204N WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					SKILL CODE/ LEVEL	QTY.	%	TIME REQUIRED	EQUIPMENT CODE	QTY.	%	HRS.	
035	MAN RGR	Imp	1.0	TRANSIT	0UHD	1			01 FLOD1	1		.01	Transport & Inspect Loads
				SETUP									
				PROCESS	3509	1		.02	Pm0922	1		.02	
040		Prim	1.0	TRANSIT									Prime and Dry
				SETUP	1.01 3509	1		.01	Pm0922	1		1.01	
				PROCESS					Pm0438	1		.01	
040A		Prim	1.0	TRANSIT									1st Load one side only
				SETUP	3509	1		.01	Pm0922	1		.01	
				PROCESS					Pm0436	1		.01	
040B		Prim	1.0	TRANSIT									2nd Load & Dry 1 side only
				SETUP	.5 3509	1		.01	Pm0922	1		.5	
				PROCESS					Pm0437	1		.01	
040C		Unld	1.0	TRANSIT									unload & Inspect
				SETUP					Pm0922	1		.02	
				PROCESS	Y609	1		.02	Pm0928	1		.02	

352 backing plate

DR

OPERATION PROFILE

NAME Kelstern ALC _____ DATE _____ RCC _____ SHEET 2 OF 2

WCD 16204N WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	Skill Code/Level	QTY.	%	HRS.	QTY.	HRS.	
050	UNKN RGP	Rivet	1.0	TRANSIT									Rivet friction pads
				SETUP									
				PROCESS			Y609	1		.05	1	.05	
060		Acpt	1.0	TRANSIT									Acceptance of repairwork
				SETUP									
				PROCESS			Y609	1		.02			
070		Insp	1.0	TRANSIT									Final visual inspect.
				SETUP									
				PROCESS			Y609	1		.02			
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

B-52 backing plate

? 70

OPERATION PROFILE

B-52 ROTOR ASSY (SPEL)

NAME D. DUESLOSS ALC 00 DATE 7 Jul 89 RCC MTANPGW SHEET 1 OF 1

(GSD)

NSN 15068A

WCD 16205N

WCD DATE 890820

PM 15068A															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
5	MAN PGW	Disc	1.00	TRANSIT											REMOVE ANY F.M.
				SETUP											
				PROCESS			H307	1	100	.01	W80001	1	100	.01	
5A	MAN PGW	Stack	1.00	TRANSIT											on Pallet
				SETUP											
				PROCESS			H307	1	100	.02					
20A	MAN PGW	LOAD	1.00	TRANSIT											ROTORBLAST MAGNET HOODS
				SETUP											
				PROCESS			H307	1	100	.01	PM7432	1	50	.01	
20	MAN PGW	CLN	1.00	TRANSIT											ROTORBLAST
				SETUP			H307	1	100	.01					
				PROCESS				100	.00			PM7432	1	100	
20B	MAN PGW	UNLN	1.00	TRANSIT											ROTORBLAST TO Pallet
				SETUP											
				PROCESS			H307	1	100	.01	PM7432	1	50	.01	

401-4-133

1.5C-21112C

OPERATIONAL PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 3

WCD 16205N WCD DATE 89040

15068A

15068A																	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
					%	HRS.	Skill CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.		
				TRANSIT													
				SETUP													
				PROCESS													
30	MAN PNA	MAG 1.0		TRANSIT			OVHD	1	.10	FL 0001	1	.10					
				PROCESS			DB09	1	.10	PM 6668	1	.10					
30A	MAN PNA	DEGR 1.0															
				PROCESS			DB09	1	.07	PM 3428	1	.07					
				TRANSIT													
				SETUP													
				PROCESS													
				TRANSIT													
				SETUP													
				PROCESS													

OPERATIONAL PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 3

PCN
NSN
PM

WCD 16205

WCD DATE

15068A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.
				TRANSIT								
				SETUP								
				PROCESS								
80	MAN PNA	MAG	1.0	TRANSIT		OVHD	1	.10	.10	1	.10	.10
				PROCESS		DBO9	1	.10	.10	1	.10	.10
				PROCESS		DBO9	1	.07	.07	1	.07	.07
80A	MAN PNA	DEGR	1.0	TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

OPERATION PROFILE

NAME Turner ALC 00 DATE 5-24-89 RCC MANPBA SHEET 1 OF 1

WCD 16205N WCD DATE 89040

15068A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MAINPOWER		EQUIPMENT		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	QTY.	HRS.	
SS	MAN	Modi	.10	TRANSIT			JA II	1				
	PRA			SETUP			JA II	1		PM 5268	.56	
				PROCESS			JA II	1		PM 5268	1.53	
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

OPERATION PROFILE

02

NAME <u>Turner</u>		ALC <u>00</u>	DATE <u>5-24-87</u>	RCC <u>MANPRB</u>	SHEET <u>1</u> OF <u>1</u>	
PCH NSN PM	WCD <u>16205N</u>		WCD DATE <u>89040</u>			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER
						SKILL CODE/ LEVEL
						QTY.
						%
						HRS.
						EQUIPMENT CODE
						QTY.
						%
						HRS.
						DATA SOURCE COMMENTS

60	MAN PRB	Grin	1.0	TRANSIT																		
				SETUP																		
				PROCESS																		
					TRANSIT																	
					SETUP																	
					PROCESS																	
					TRANSIT																	
					SETUP																	
					PROCESS																	

W/R

OPERATION PROFILE

NAME Kerstan, Kyle ALC 00 DATE 5-22-87 RCC Broken SHEET 1 OF 1

WCD 16205N WCD DATE 07040												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.		%	HRS.		%	HRS.
085	MAN REP	Imp	1.0	TRANSIT SETUP PROCESS			4609	1	05			Inspect Rohr segment
085A	MAN REP	Rep	30	TRANSIT SETUP PROCESS			4609	1	1	R700H	1	Tighten segment bolts as required
090	MAN REP	dip	1.0	TRANSIT SETUP PROCESS		.5	4609	1	02	D700H	1	oil dip
100		Imp	1.0	TRANSIT SETUP PROCESS								Final Insp. paperwork
				TRANSIT SETUP PROCESS			4609	1	02			
				TRANSIT SETUP PROCESS								
				TRANSIT SETUP PROCESS								

B-52 Rohr Segment Assy

OPERATION PROFILE

B-52 BRAKE ASSY

NAME D. Divelbiss ALC 00 DATE 5 Jun 89 RCC MANPGW SHEET 1 OF 1

WCD <u>16213N</u>		WCD DATE <u>88266</u>														
150608		MANPOWER														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
1	MAN PGW	IND	1.00													DAVE ZUPAN
				PROCESS												
2	MAN PGW	SPLT	1.00	SETUP			H805	2	100	.05	PM0131	1	100	.05		H012 NO TEL
				PROCESS			H805	2	10	1.00		10	1.00			
							H805	2	90	.25	W00001	1	90	.25		
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

OPERATION PROFILE

012

NAME <u>KEPANA</u> ALC <u>00</u> DATE <u>5-23-89</u> RCC <u>Brakes</u> SHEET <u>1</u> OF <u>1</u>												
WCD <u>162191</u> WCD DATE <u>90266</u>												
WCD <u>15068A</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	Skill CODE/LEVEL	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	DATA SOURCE COMMENTS
020	MAN P&P	INTL	1.0	TRANSIT	%	Y609	1	%	W4005	1	%	Clean, inspect & inspect panels
				SETUP	MRS.			MRS.			MRS.	
				PROCESS								
025		ASM	.50	TRANSIT	%	Y609	1	%	W4005	1	%	Plug crosshairs ports
				SETUP	MRS.			MRS.			MRS.	
				PROCESS								
025A		ASM	.85	TRANSIT	%	Y609	1	%	W4005	1	%	Install return spring bushing
				SETUP	MRS.			MRS.			MRS.	
				PROCESS								
025B		ASM	1.0	TRANSIT	%	Y609	1	%	W4005	1	%	Assemble cylinders, adjusters, return springs, pressure plate, & seal & wire & adjuster
				SETUP	MRS.			MRS.			MRS.	
				PROCESS								
025C		ASM	1.0	TRANSIT	%	Y609	1	%	CE 98	1	%	Brake plate shading
				SETUP	MRS.			MRS.			MRS.	
				PROCESS								
									B50001	1		.33

B52 Brake Assy

OPERATION PROFILE

AR

NAME VERBAND ALC 00 DATE 5-23-89 RCC Brakes SHEET 2 OF 2

WCD 16219N WCD DATE 882606

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
030	UNAD PGP	Test	1.0	TRANSIT		Y609	1	7	PM0449	1	7	Test & Adjust Braking
				SETUP								
				PROCESS								
040		Asy	1.0	TRANSIT								Recals and finish
				SETUP								
				PROCESS		Y609	1	16	PM0933	1	16	
050		Acpt	1.0	TRANSIT								Acceptance of paperwork
				SETUP								
				PROCESS		Y609	1	02				
060		Imp	1.0	TRANSIT								Final Visual Inspection
				SETUP								
				PROCESS		Y609	1	02	PM0933	1	02	
9999		Se11	1.0	TRANSIT								
				SETUP								
				PROCESS								

B-52 Brake Assy

1.50.20M200

OPERATION PROFILE

NAME KERITHAN ALC DATE WCD P16201 RCC MAN P&P-Bakes SHEET 1 OF 1

WCD P 16201		WCD DATE 89208	
WCD P 16201		WCD DATE 89208	
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B-52 Brake cylinder and return springs Assemblies
 pseudo WCD # P16201 Note 12 per Brake Assy

WR

OPERATION PROFILE

05A-Brake Assy

NAME <u>D. DIVELEISS</u>		ALC <u>00</u>		DATE <u>12 June 89</u>		RCC <u>MANPGW</u>		SHEET <u>1</u> OF <u>1</u>				
WCD <u>15698A</u>		WCD <u>21208N</u>		WCD DATE <u>890400</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %		
1	MAN PGW	IND	1.000	TRANSIT								Davis Zupan
				SETUP								
				PROCESS								
5	MAN PGW	SLT	1.000	TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

T.O. AB1-2-10063

1.50-300020

(CW)

DR

OPERATION PROFILE

C-5A BRACE - Backing Plate (Ti)

NAME D. DUNELEBS ALC 00 DATE 12 JUN 89 RCC MTAN PGW SHEET 1 OF 1

WCD 21201N WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS %	Skill CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	
5	MTAN PGW	DIS	1.000	TRANSIT									REM Bolts + SEP Plate From TILLOS
				SETUP									
				PROCESS		H305	1	100	.03	W80002	1	100	
5A	MTAN PGW	Stack	1.000	TRANSIT									Torque TUBA to Pallet
				SETUP									
				PROCESS		H305	1	100	.03				
5B	MTAN PGW	Stack	1.000	TRANSIT									Bacini Plates to 2nd Pallet
				SETUP									
				PROCESS		H305	1	100	.03				
5C 2A	MTAN PGW	UNLO	1.000	TRANSIT									IN NAOZ TANK DEGRASS + Cold Water Rinse
				SETUP									
				PROCESS		H305	1	100	.02	W80002	1	100	
9	MTAN PGW	DEGR.	1.000	TRANSIT									
				SETUP									
				PROCESS	100	H305	1	100	.08	W80002	1	100	

186331000

OPERATION PROFILE

C-5A BAKES - (Baking Place (pi))

NAME D. DAVIS ALC 00 DATE 12 Jun 89 RCC MAN PGW SHEET 2 OF 7

WCD 21201N WCD DATE 89045

15698A

PCD
HSH
PIN

15698A		MANPOWER												EQUIPMENT			DATA SOURCE COMMENTS
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED				
					%	HRS.			%	HRS.			%	HRS.			
9B	MAN PGW	CLN	1.00	TRANSIT												Water Blast - Vapor Hose	
				SETUP													
				PROCESS	100	.17	H305	1	100	.16	PM5653	1	100	.17			
9C	MAN PGW	Rinse	1.00	TRANSIT												Hot Water	
				SETUP													
				PROCESS	100	.02	H305	1	100	.02	PM5653	1	100	.17			
9D	MAN PGW	Rinse	1.00	TRANSIT												Cold Rinse	
				SETUP													
				PROCESS	100	.02	H305	1	100	.02	PM5653	1	100	.02			
9E	MAN PGW	Stack	1.00	TRANSIT												To Pallet	
				SETUP													
				PROCESS					100	.02							
9F		MOVE	1.00	TRANSIT												To Heat Treat	
				SETUP													
				PROCESS													

OPERATIONAL PROFILE

C-5A GRAVE JACKING HEAD - (REV)

NAME D. D. LUEBBS ALC 00 DATE 12 Jun 89 RCC MTANPGW SHEET 3 OF 4

WCD 21201N WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.			%	HRS.			%	HRS.	
30	MAN PGW	INSP	1.00	TRANSIT											FLATNESS #1
				SETUP											
				PROCESS				DI07 1	40 .17 60 .35		1	40 .17 60 .35			
30A	MAN PGW	STACK	1.00	TRANSIT											on Pallet
				SETUP											
				PROCESS				DI07 1	100 .02						
30B	OUHD PLW	MOVE	1.00	TRANSIT											TO FPI LINE
				SETUP											
				PROCESS				DI07 1	100 .08		1	100 .08			
60	MAN PGW	INSP	1.00	TRANSIT											FLATNESS #2
				SETUP											
				PROCESS				DI07 1	40 .17 60 .35		1	40 .17 60 .35			
60A	MAN PGW	STACK	1.00	TRANSIT											on Pallet
				SETUP											
				PROCESS				DI07 1	100 .02						

NR

OPERATION PROFILE

C-5A BRAKE - (BRADING PLATE (T))

NAME D. DUBESS ALC 00 DATE 12 Jun 89 RCC TRANPGW SHEET 4 OF 4

PCN 15698A WCD 21201N WCD DATE 89045

NSN 15698 A														DATA SOURCE COMMENTS		
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			TIME REQUIRED			
					%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.		
600	OUHO PHW	ITTOUE	1.000	TRANSIT											TU FPI	
				SETUP												
				PROCESS		OUHO	1	100.00	1.00	100.00	1	100.00	1.00			
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

TO FPI

OPERATION PROFILE

C-5A BRIGADE - STATION/Carrier (B2)

NAME D. DIVERGESS ALC 00 DATE 12 JUN 89 RCC MANPSW SHEET 1 OF 4

WCD <u>21202N</u>		WCD DATE <u>89095</u>		WCD <u>15698A</u>		WCD <u>21202N</u>		WCD DATE <u>89095</u>	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER	EQUIPMENT	TIME REQUIRED	DATA SOURCE COMMENTS
					%	QTY.	EQUIPMENT CODE	%	
5	MAN PEN	DIS	1.00	TRANSIT					REM. FAPS
				SETUP					
				PROCESS					
				TRANSIT					
				SETUP					
				PROCESS					
5A	MAN PEN	STACK	1.00	TRANSIT					on pallet
				SETUP					
				PROCESS					
				TRANSIT					
				SETUP					
				PROCESS					
5B 9x	MAN PEN	UNLD	1.00	TRANSIT					UNLD
				SETUP					
				PROCESS					
				TRANSIT					
				SETUP					
				PROCESS					
9B	MAN PEN	DEGR	1.00	TRANSIT					NAC2
				SETUP					
				PROCESS					
				TRANSIT					
				SETUP					
				PROCESS					
9C	MAN PEN	RINSE	1.00	TRANSIT					Cold H2O
				SETUP					
				PROCESS					

T.O. 431-2-1063

OPERATION PROFILE

C-5A BRAKE - SIGMA / SARTER

NAME <u>D. DIVISALIS</u>		ALC <u>00</u>		DATE <u>12 JUN 89</u>		RCC <u>MTAN/PGW</u>		SHEET <u>2</u> OF <u>4</u>						
PCN <u>15698A</u>		WCD <u>21202 N</u>		WCD DATE <u>89045</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.
9	MTAN PGW	CLN	1.000	TRANSIT								WET BRIST Vapor-Hose		
				SETUP										
				PROCESS										
90	MTAN PGW	RINSE	1.000	TRANSIT								Cold H ₂ O		
				SETUP										
				PROCESS										
9E	MTAN PGW	Proc	1.000	TRANSIT								Wet Stone		
				SETUP										
				PROCESS										
9F	MTAN PGW	Rinse	1.000	TRANSIT								Hot H ₂ O		
				SETUP										
				PROCESS										
9G	MTAN PGW	Stack	1.000	TRANSIT								on Pallet		
				SETUP										
				PROCESS										

OPERATION PROFILE

C-5A BRAKE - STATOR / CARBON

SHEET 3 OF 4

NAME D. Divisio ALC 00 DATE 12 JUN 89 RCC MTAN PGW

WCD 2202N WCD DATE 89045

NSN 15698A PM

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
					MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED			EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%	HRS.			%	HRS.				%	HRS.
94	OUHO PGW	MOVE	1.00	TRANSIT									NO HEAT TREAT		
				SETUP											
				PROCESS				OUHO	1	100.00	100.00	1		100.00	100.00
30A	MTAN PGW	LIND	1.00	TRANSIT									TO ROLLER CONV.		
				SETUP											
				PROCESS				DI07	1	100.00	100.00	1		100.00	100.00
30	MTAN PGW	INSP	1.00	TRANSIT									FLATNESS		
				SETUP											
				PROCESS						40	40.00	1		60	60.00
30B	MTAN PGW	STAKE	1.00	TRANSIT									on roller		
				SETUP											
				PROCESS				DI07	1	100.00	100.00	1		100.00	100.00
30C	OUHO PGW	MOVE	1.00	TRANSIT									TO FPI		
				SETUP											
				PROCESS				OUHO	1	100.00	100.00	1		100.00	100.00

OPERATION PROFILE

CSA BRIDGE

NAME D. DUBELISS ALC. 00 DATE 12 JUN 88 RCC TRANP&W SHEET 4 OF 4

WCD 21202N WCD DATE 880415

15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
60A	TRAN P&W	UNLO	1.00	TRANSIT							FROM OH P Roller Conv.
				SETUP							
				PROCESS							
60B	TRAN P&W	Insp	1.00	TRANSIT							E.I. - FLATNESS
				SETUP							
				PROCESS							
60C	TRAN P&W	Stack	1.00	TRANSIT							on pallet
				SETUP							
				PROCESS							
60D	QUAD P&W	MOVE	1.00	TRANSIT							TO FFI
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

Needs to be entered

18

OPERATION PROFILE

NAME <u>Verghara</u>		ALC		DATE		RCC <u>MANIPAL-Bakes</u>		SHEET <u>1</u> OF <u>1</u>					
WCD <u>P21206</u>		WCD DATE <u>89200</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER		EQUIPMENT		TIME REQUIRED	DATA SOURCE COMMENTS		
					%	QTY.	%	QTY.	%	HRS.			
010A	MAN PGP	Dis	1.0	TRANSIT		1					Disassemble		
				SETUP									
				PROCESS									
020A		CLN	1.0	TRANSIT		1					Clean		
				SETUP									
				PROCESS									
030A		IMP	1.0	TRANSIT							Inspect		
				SETUP									
				PROCESS									
040A		Assy	1.0	TRANSIT							Assemble		
				SETUP									
				PROCESS									

C-5A Cylinder Assy
Pardo WCD# P21206
8 per Assy

FORM 105-1

OPERATION PROFILE

C-50 SNOXZ - BATOR / CARRIER (B2)

NAME <u>D. DIVELISS</u> ALC <u>OC</u> DATE <u>12 JUN 89</u> RCC <u>MANPQW</u> SHEET <u>1</u> OF <u>1</u>										
WCD <u>21263N</u> WCD DATE <u>89054</u>										
15698A										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER	EQUIPMENT	TIME REQUIRED	TIME REQUIRED	DATA SOURCE COMMENTS
					%	QTY.	SKILL CODE/ LEVEL	%	HRS.	
S	MAN PGW	Dis	1.00	TRANSIT						REM-PADS
				SETUP						
				PROCESS						
Sa	MAN PGW	Struck	1.00	TRANSIT						on Pallet
				SETUP						
				PROCESS						
Sa	MAN PGW	UNLO	1.00	TRANSIT						UNLOAD
				SETUP						
				PROCESS						
Sb	MAN PGW	DEGR	1.00	TRANSIT						NAO2
				SETUP						
				PROCESS						
Sc	MAN PGW	Rins	1.00	TRANSIT						Cold H2O
				SETUP						
				PROCESS						

TR. 4B1-2-1063

AK

OPERATION PROFILE

C-5A Brake - Rotary Carrier

NAME <u>D. DIVELESS</u>		ALC <u>DC</u>		DATE <u>12 JUN 89</u>		RCC <u>MTANPGW</u>		SHEET <u>2 OF 4</u>						
WCD <u>212430</u>		WCD <u>89054</u>		WCD <u>89054</u>		WCD <u>89054</u>		WCD <u>89054</u>						
15698A		15698A		15698A		15698A		15698A						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
9	MTAN PGW	CUN	1.00	TRANSIT										Wet Blast Vapor Hone
		SETUP												
		PROCESS												
90	MTAN PGW	RINSE	1.00	TRANSIT										Cold H ₂ O
		SETUP												
		PROCESS												
9E	MTAN PGW	Proc.	1.00	TRANSIT										Wet Stone
		SETUP												
		PROCESS												
9F	MTAN PGW	RINSE	1.00	TRANSIT										Hot H ₂ O
		SETUP												
		PROCESS												
9G	MTAN PGW	STACK	1.00	TRANSIT										on pallet
		SETUP												
		PROCESS												

OPERATION PROFILE

C-SA (Spare - Motor / Carrier)

NAME D. Dineen ALC 00 DATE 12 Jun 89 RCC THAMES SHEET 3 OF 4

WCD 212032															WCD DATE 89054														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS															
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		HRS.														
									%	HRS.			%	HRS.															
304	CUMD P6W	MOVE	1.00	TRANSIT												MOVE TO HEAR TRAIL													
				SETUP																									
				PROCESS																									
30A	MAN P6W	UNLO	1.00	TRANSIT												TO RAILER CONV.													
				SETUP																									
				PROCESS																									
30	MAN P6W	INSP	1.00	TRANSIT												FLATNESS													
				SETUP																									
				PROCESS																									
30B	MAN P6W	STACK	1.00	TRANSIT												ON PALLET													
				SETUP																									
				PROCESS																									
30C	CUMD P6W	MOVE	1.00	TRANSIT												TO FPI													
				SETUP																									
				PROCESS																									

WCD DATE 89054

WCD 21203N

15698A

OPERATION PROFILE

C-SA BLAKE - KERN / CARRIER

NAME D. Divisio ALC 00 DATE 12 JUN 89 RCC TRANSW SHEET 4 OF 4

PCN
RSH
PIN

15698A

WCD 21203N

WCD DATE 89054

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	
60A	MAN RSH	UNLO	1.00	TRANSIT							OH CONU. TO MILLER CONU.
				SETUP							
				PROCESS							
60B	MAN RSH	INSP	1.00	TRANSIT							FURNACE #2
				SETUP							
				PROCESS							
60C	MAN RSH	STACH	1.00	TRANSIT							on roller
				SETUP							
				PROCESS							
60D	MAN RSH	MOVE	1.00	TRANSIT							TO FPI
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

DR

OPERATION PROFILE

C-5A Brake - End Plate/Carrier (GSA)

NAME D. Diwelbiss ALC 00 DATE 12 Jun 89 RCC MANPGW SHEET 1 OF 4

PCN		NSN		PN		15698A		WCD		21204N		WCD DATE		88083				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS		
					%	HRS.		QTY.	%	HRS.	%			HRS.				
5	MAN REW	DIS	1.00	TRANSIT												REM. Pags.		
				SETUP														
				PROCESS														
5A	MAN REW	Stack	1.00	TRANSIT												on Pallet		
				SETUP														
				PROCESS														
9A	MAN REW	UNLO	1.00	TRANSIT												UNLOAO		
				SETUP														
				PROCESS														
9B	MAN REW	DEGR.	1.00	TRANSIT												NA Q2		
				SETUP														
				PROCESS	100	.25												
9C	MAN REW	Rinse	1.00	TRANSIT												Cold H2O		
				SETUP														
				PROCESS	100	.03												

T.O. 4BA-2-1063

ISC-200000

OPERATION PROFILE

C-5A (Snake) - ENO PLATE / COASTER

NAME D. DIVELOISS ALC 00 DATE 12 JUN 89 RCC MTANP5W SHEET 2 OF 4

PCN		15698A		WCD 21204N		WCD DATE 88083										
NRN	PN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
							%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	QTY.	%	HRS.	
9	MAN PGW	CLN	1.00			TRANSIT										
						SETUP										
						PROCESS										
9D	MAN PGW	RINSE	1.00			TRANSIT										
						SETUP										
						PROCESS										
9E	MAN PGW	PROC.	1.00			TRANSIT										
						SETUP										
						PROCESS										
9F	MAN PGW	RINSE	1.00			TRANSIT										
						SETUP										
						PROCESS										
9G	MAN PGW	STACK	1.00			TRANSIT										
						SETUP										
						PROCESS										

WCD 21204N WCD DATE 88083

15698A

OPERATION PROFILE

C-S A Brake - END PLATE / CARBIDE

NAME D. DIVELEISS ALC 00 DATE 12 JUN 89 RCC MTAN PGW SHEET 3 OF 4

WCD 21204 N WCD DATE 88083

PCN 15698A

OPERATION NUMBER		RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
29	OVHD PGW	MOVE	1.00	TRANSIT										MOVE TO HEAT TREAT	
				SETUP											
				PROCESS				OVHD	1	100	.08	F00003	1		100
30A	MTAN PGW	UNLO	1.00	TRANSIT										TO CONVEYOR - KOLLER	
				SETUP											
				PROCESS				DI07	1	100	.03	C000003	1		100
30	MTAN PGW	INSP	1.00	TRANSIT										FLATNESS	
				SETUP											
				PROCESS				DI07	1	40	.08	F00001	1		40
30B	MTAN PGW	STACK	1.00	TRANSIT										ON PALLET	
				SETUP											
				PROCESS				DI07	1	60	.17		1		60
30C	OVHD PGW	MOVE	1.00	TRANSIT										TO FPI	
				SETUP											
				PROCESS											

OPERATION PROFILE

C-5A (BROKE - END YARE / CARRICA

NAME D. DINEGLISS ALC 00 DATE 12 JUN 89 ACC MANPGW SHEET 4 OF 4

WCD 21204N WCD DATE 88083

15698A

OPERATION NUMBER	ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.	
60A	MAN PGW	UNLO	1.000	TRANSIT										From O.H. To Roller Conveyor		
				SETUP							Pm0901	1	100		103	
				PROCESS												
60B	MAN PGW	Insp	1.000	TRANSIT										EFT - Flatness #2		
				SETUP												
				PROCESS												
60C	MAN PGW	Stack	1.000	TRANSIT										on pallet		
				SETUP												
				PROCESS												
60D	OVHO PGW	MOVE	1.000	TRANSIT										TO FFI		
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

OPERATION PROFILE

C-5A BRAKE - Piston Housing (AL)

NAME D. DWELBESS ALC 00 DATE 12 JUN 89 RCC MAN PGW SHEET 1 OF 5

WCD 21206N WCD DATE 89037

PCN 15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
4A	MAN PGW	LIND	1.00	TRANSIT							UNLOAD
				SETUP							
				PROCESS							
4B	MAN PGW	DEGUM	1.00	TRANSIT							N402
				SETUP							
				PROCESS	100	1	100		1	100	
4C	MAN PGW	RINSE	1.00	TRANSIT							Cold H ₂ O
				SETUP							
				PROCESS	100	1	100		1	100	
4	MAN PGW	CLN	1.00	TRANSIT							Vapor Hone (Wet Blast)
				SETUP							
				PROCESS							
4D	MAN PGW	RINSE	1.00	TRANSIT							HOT H ₂ O
				SETUP							
				PROCESS	100	1	100		1	100	

T.O. 4B1-2-10063 / 4B1-2-1203

15C-20002C

OPERATION PROFILE

C-5A BRIDGE - PISTON HOUSING (AL)

NAME D. DUNN ALC 00 DATE 12 June 89 RCC MANPGW SHEET 2 OF 5

WCD 212000 WCD DATE 890037

15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
4E	MAN REW	STACK	1.00	TRANSIT							On Pallet
				SETUP							
				PROCESS		1	100.03				
4F	OUMD REW	MOVE	1.00	TRANSIT							To Diss Area
				SETUP							
				PROCESS		1	100.108	FL00003	1	100.103	
5	MAN REW	DIS	1.00	TRANSIT							REM Pistons
				SETUP							
				PROCESS		1	60.25 40.50			60.25 40.50	
5A	MAN REW	REM	1.00	TRANSIT							Clips
				SETUP							
				PROCESS		1	100.17	W000002	1	100.17	
50	MAN REW	LOAD	1.00	TRANSIT							O.H. Conveyor
				SETUP							
				PROCESS		1	100.104	W000002	1	100.104	

OPERATION PROFILE

C-5A BRAKE - PISTON HOUSING (AC)

NAME D. DAVIS ALC. 00 DATE 12 JUN 89 RCC 17AN/PGW SHEET 3 OF 5

WCD 21206N WCD DATE 890337

15698A

PCN
RSH
PM

NSA
PM

15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED			
									%	HRS.			%	HRS.		
7	MAN PGW	CLN	1.00	TRANSIT							Pm0901	1	100	3.47	CHEN CLEAN LINE ALT Pm0908 Pm 0926 Pm 0934 FROM QH, TO Kevler Conveyor	
				SETUP			KIOS	1	100.00							
				PROCESS	100	2.89				Pm0916	1	100	3.47			
7B	MAN PGW	LNLO	1.00	TRANSIT							Pm0901	1	100	1.04	BLAST	
				SETUP												
				PROCESS			KIOS	1	100.00	100	1.04	100	1.04			
9	MAN PGW	CLN		TRANSIT											ALT. Pm0412	
				SETUP			KIOS	1	100.00							
				PROCESS			KIOS	1	20.00	.25	20	.40	80	.25		
9B	MAN PGW	TRANS	1.00	TRANSIT							Pm0901	1	100	1.08	O.M. CONV. TO ANDRZE Strip	
				SETUP												
				PROCESS												
12	MAN PGW	PROC.	1.00	TRANSIT							Pm0901	1	100	1.03	ANDRZE Strip	
				SETUP			KIOS	1	100.00							
				PROCESS	100	.86										
											Pm0901	1	100	1.03	ALT. Pm 0635	

OPERATION PROFILE

C-5A Brake - Piston Housing (AL)

NAME D. Dives ALC 00 DATE 12 Jun 89 RCC MANPGW SHEET 4 OF 5

PCN
INSH
PM

15698A

WCD 21206N

WCD DATE 89037

15698A			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.	%			HRS.		
12A	MAN PGW	TRANS	1.00	TRANSIT											To FEI Line (Automatic)	
				SETUP												
				PROCESS												
13A	MAN PGW	UNLO	1.00	TRANSIT											From O.H. Conv. to Roller Conv.	
				SETUP												
				PROCESS												
13	MAN PGW	Proc	1.00	TRANSIT											ACT. PM0411	
				SETUP												
				PROCESS												
13B	MAN PGW	LOAD	1.00	TRANSIT											To Roller Conv.	
				SETUP												
				PROCESS												
30	MAN PGW	INSP.	1.00	TRANSIT											E.T.I	
				SETUP												
				PROCESS												

OPERATION PROFILE

DR

C-SA Brake - Piston Housing (41)

NAME D. DIVELESS ALC 00 DATE 12 JUN 89 RCC MANPGW SHEET 5 OF 5

WCD 21206N WCD DATE 850331

156984

PCN

NSM

PM

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
							QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.
304	MAN PGW	EATCH	1.00	TRANSIT									To Pallet
				SETUP									
				PROCESS			1	100	.03				
305	OVHD PHW	MOVE	1.00	TRANSIT									To Machine Shop
				SETUP									
				PROCESS			1	100	.08	FL-00003	1	100	.08
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

C.5A BRAKE-TORQUE TUBE (T₂)

NAME D. DIVERGESS ALC 00 DATE 12 Jun 89 RCC MANPGW SHEET 1 OF 3

SHEET 1 OF 3

RCC TRANPGW

DATE 12 Jun 89

00

ALC

D. Dufress

NAME:

WCD DATE 89131

WCD 21207N

15698A

[illegible]

T.O. 4B1-2-1003/4B1-2-1203

151-152

OPERATION PROFILE

C-5A Brake - Tensque Tube (27)

NAME D. O. L. BISS ALC 00 DATE 12 JUN 89 RCC MANPGW SHEET 2 OF 3

PCN			NSN			PIN			WCD			WCD DATE			EQUIPMENT			DATA SOURCE COMMENTS				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		EQUIPMENT	DATA SOURCE COMMENTS					
					%	HRS.		QTY.	%	HRS.	%			HRS.								
9	MAN PGW	CLN	1.00	TRANSIT													WET BRIST Vapor Hone					
				SETUP																		
				PROCESS																122		
					100	.17																
9D	MAN PGW	Rinse	1.00	TRANSIT													HOT H ₂ O					
				SETUP																		
				PROCESS																		
					100	.02	H305	1	100	.02												
9E	MAN PGW	Rinse	1.00	TRANSIT													Cold H ₂ O					
				SETUP																		
				PROCESS																		
					100	.02	H305	1	100	.02												
9F	MAN PGW	Stack	1.00	TRANSIT													on pallet					
				SETUP																		
				PROCESS																		
9H	OUTD PGW	Move	1.00	TRANSIT													TO FPI LINE					
				SETUP																		
				PROCESS																		

02

OPERATION PROFILE

C-SA BRACKET - TENSURE TUBE (Ti)

NAME D. DIVELEISS ALC 00 DATE 12 Jun 89 RCC MANPGW SHEET 3 OF 3

WCD 21207N WCD DATE 82131

PCN 15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
19A	MAN PGW	UNLD	1.000	TRANSIT							OH Conv to 120116 Conv
				SETUP				Pm0901	1	100 .03	
				PROCESS							
19	MAN PGW	Proc	1.00	TRANSIT							Nick & Bun
				SETUP							
				PROCESS							
20	MAN PGW	INSF	1.00	TRANSIT							Act. Pm0411
				SETUP							
				PROCESS							
20A	MAN PGW	STOCK	1.00	TRANSIT							on pallet
				SETUP							
				PROCESS							
20B	MAN PGW	MOVE	1.00	TRANSIT							to Machine Swap.
				SETUP							
				PROCESS							

1.50-2000000

OPERATION PROFILE

C-5A BRAKE - PRESSURE PLATE (SPEEL)

NAME <u>D. DIVELEISS</u> ALC <u>00</u> DATE <u>12 JUN 89</u> RCC <u>MTANPGW</u> SHEET <u>1 OF 3</u>		WCD <u>212000N</u> WCD DATE <u>890404</u>		MANPOWER		EQUIPMENT		TIME REQUIRED		TIME REQUIRED		DATA SOURCE	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	%	HRS.	QTY.	%	HRS.	COMMENTS
3	MAN PGW	DEGR	1.00	TRANSIT	100	H3005	1	100	1.00	1	100	1.00	NAO ₂ Sunk
4	MAN PGW	CLN	1.00	TRANSIT	100	H3005	1	100	1.00	1	100	1.00	WET Blast Vapor Hone
4B	MAN PGW	Rinse	1.00	TRANSIT	100	H3005	1	100	1.00	1	100	1.00	Hot H ₂ O
4C	MAN PGW	Rinse	1.00	TRANSIT	100	H3005	1	100	1.00	1	100	1.00	Cold H ₂ O
5	MAN PGW	Dis	1.00	TRANSIT	100	H3005	1	100	1.00	1	100	1.00	Rem Sur Serv

OPERATION PROFILE

NAME D. DINELEISS ALC 00 DATE 12 JUN 85 RCC TRAADBGW SHEET 2 OF 3

PCN NSN PM			15698A			WCD 21209 N			WCD DATE 89090			EQUIPMENT			DATA SOURCE COMMENTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
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5A	MAN PGW	Stack	1.00	TRANSIT													on pallet																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
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5B	OUMD PGW	move	1.00	TRANSIT													move to 34 D rotorblast																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
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8B	MAN PGW	UNLO	1.00	TRANSIT													UNLOAD near Hooks																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
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OPERATION PROFILE

C-5AIBNAKE - Pressure Plate (SPEL)

SHEET 3 OF 3

NAME D. DIVELESS ALC 00 DATE 12 JUN 89 RCC VIANP6W

WCD 21209N

WCD DATE 85040

15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			SKILL CODE/LEVEL	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					%	HRS.			QTY.	%	HRS.	TIME REQUIRED %	QTY.	TIME REQUIRED %	
80	MAN P6W	STACK	1.00	TRANSIT											on Pallet
				SETUP											
				PROCESS				H305	1	100	102				
80	OVHD P6W	MOVE	1.00	TRANSIT											TO FMP
				SETUP											
				PROCESS				OVHD	1	100	100	100	1	100	
20	MAN P6W	INSP	1.00	TRANSIT											E&I
				SETUP											
				PROCESS				DIC07	1	30	17	30	1	30	
20A	MAN P6W	STACK	1.00	TRANSIT											on Pallet
				SETUP											
				PROCESS				DIC07	1	70	35	70	1	70	
20B	OVHD P6W	MOVE	1.00	TRANSIT											TO machine Shop
				SETUP											
				PROCESS					1	100	103				
20B	OVHD P6W	MOVE	1.00	TRANSIT											TO machine Shop
				SETUP											
				PROCESS					1	100	108	100	1	100	

OPERATION PROFILE

NAME <u>MEL ANDERSON</u> ALC <u>00</u> DATE <u>5-31-89</u> RCC <u>MANPGW</u> SHEET <u>1</u> OF <u>2</u>												
WCD <u>21201N</u> WCD DATE <u>89045</u>												
NSN <u>156984</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	MANPOWER QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
40	MAN PGW	LOAD	1.0	TRANSIT								
				SETUP								
				PROCESS								
40A	MAN PNA	FPI	.25	TRANSIT								
				PROCESS								
				PROCESS								
40B	MAN PNA	FPI	.75	TRANSIT								
				PROCESS								
				PROCESS								
40C	MAN PGW	UNLO	1.0	TRANSIT								
				PROCESS								
				PROCESS								

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 2

WCD 212012 WCD DATE 89045

WCD 212012

156984

PCN
NSN
PIN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	%	HRS.	
70	MAN PGW	LOAD	.30	TRANSIT									
				SETUP									
				PROCESS									
				PROCESS			KI07	1		.05		.05	
70A	MAN PNA	FPI	.08	TRANSIT								.02	
				PROCESS								1.10	
				PROCESS								1.10	
				PROCESS			DB09	1		.10		1.10	
70B	MAN PNA	FPI	.23	TRANSIT								.02	
				PROCESS								1.05	
				PROCESS				2		.05		1.05	
				PROCESS			DB09	2		.05		1.05	
70C	MAN PGW	UNLD	1.0	TRANSIT								.05	
				PROCESS									
				PROCESS									
				PROCESS			KI07	1		.05		.05	

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OPERATION PROFILE

CS A + D

NAME <u>UNIFORM</u>		ALG <u>00</u>		DATE <u>5-30-89</u>		RCC <u>MANUFACTURING</u>		SHEET <u>OF</u>							
PCN <u>NSN</u>		P/N <u>15698A</u>		WCD <u>21201N</u>		WCD DATE <u>89045</u>									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	QTY.	%	HRS.	QTY.	%	HRS.			
20	MAN PWW	LOAD	1	TRANSIT			2	1.0	3		1	1.0	3	LOAD 311 WCD 3 10/87400	
				SETUP										20/LOAD	
				PROCESS											
20A	MAN PWW	HEAT	1	TRANSIT										HEAT 110 EXTEN	
				SETUP											
				PROCESS											
20B	MAN PWW	UNLOAD	1	TRANSIT			2	1.0	3		1	1.0	3	REMOV FROM	
				SETUP											
				PROCESS											
20C	MAN PWW	cool DOWN	1	TRANSIT										Air Time	
				SETUP											
				PROCESS											
20D	MAN PWW	UNLOAD	1	TRANSIT			2	1.0	3		1	1.0	3	UNLOAD FROM BACK	
				SETUP											
				PROCESS											

BERYLLIUM.

OPERATION PROFILE

C 5 A 4 B

NAME CORNFORD ALG 00 DATE 5-30-89 RCC MINIFLOW SHEET OF

PCN

NSN

P/N 15698AWCD 212010WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	EQUIPMENT CODE	QTY.	%	HRS.	
50	MAN PWW	LOAD	3070	TRANSIT			WFO8 WFO8	2	3	CE27	1	1.0	1.3	LOAD 511 M4115 10/27411
				SETUP										30/LOAD
				PROCESS										
50A	MAN PWW	HEAT	30	TRANSIT										HEAT 110 GJ20
				SETUP										
				PROCESS										
50B	MAN PWW	UNLOAD	30	TRANSIT			WFO8 WFO8	2	3	CE27	1	1	1.3	PREVIOUS FROM
				SETUP										
				PROCESS										
50C	MAN PWW	COOL DOWN	30	TRANSIT										AIRC TIME
				SETUP										
				PROCESS										
50D	MAN PWW	UNLOAD	40	TRANSIT			WFO8 WFO8	2	3	CE27	1	1.0	1.3	UNLOAD FROM PACL
				SETUP						LB9362	1	1.0	1.3	
				PROCESS						LB9361	1	1.0	1.3	
										LB9361	1	1.0	1.3	

OPERATION PROFILE

DR

NAME <u>MEL ANDERSON</u> ALC <u>00</u> DATE <u>5-31-89</u> RCC <u>MANPGW</u> SHEET <u>1</u> OF <u>3</u>														
PCN <u>15698A</u> WCD <u>21202N</u> WCD DATE <u>89045</u>														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE				QTY.
40	MAN PGW	LOAD	1.0	TRANSIT										
				SETUP										
				PROCESS										
40A	MAN PNA	FPI	.25	PROCESS										
				TRANSIT										
				PROCESS										
40B	MAN PNA	FPI	.75	PROCESS										
				TRANSIT										
				PROCESS										
40C	MAN PGW	UNLD	1.0	PROCESS										
				TRANSIT										
				PROCESS										

OPERATIONAL PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 3

WCD 212022U WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
70	MAN PGW	LOAD	.30	TRANSIT							
				SETUP							
				PROCESS							
70A	MAN PGW	LOAD	.30	TRANSIT	KI07	1		PM 0901	1	.05	
				PROCESS							
				PROCESS							
70B	MAN PNA	FPI	.23	TRANSIT				PM 0901	1	.02	
				PROCESS				PM 0901	1	1.10	
				PROCESS				PM 0679E	1	1.10	
70C	MAN PGW	UNLD	.30	TRANSIT				PM 0901	1	.05	
				PROCESS				PM 0901	1	1.05	
				PROCESS				PM 0679E	1	1.05	

DR

OPERATION PROFILE 85 A

BERYLLIUM

NAME <u>UNIFORM</u> <u>ALO</u> <u>00</u> <u>DATE 5-30-89</u> <u>RCC MANUFACT</u> <u>SHEET</u> <u>OF</u>		WCD <u>212020</u> <u>WCD DATE 89045</u>													
PCN NSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
						MANDATORY FLOW HOURS %	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.
20		MAN PWW	LOAD	1	TRANSIT		WFO8	2	1.3		CE27	1	1.0	1.3	LOAD IN PILLS 101 BAGS 201 LOAD
					SETUP										
					PROCESS										
20A		MAN PWW	HEAT	1	TRANSIT									HEAT IN OIL IN	
					SETUP										
					PROCESS										
20B		MAN PWW	UNLOAD	1	TRANSIT		WFO8	2	1.0	1.3	CE27	1	1.0	1.3	REMOV FROM
					SETUP										
					PROCESS										
20C		MAN PWW	COOL DOWN	1	TRANSIT									AIR TIME	
					SETUP										
					PROCESS										
20D		MAN PWW	UNLOAD	1	TRANSIT		WFO8	2	1.0	1.3	CE27	1	1.0	1.3	UNLOAD FROM BAGS
					SETUP										
					PROCESS										

012

BERYLLIUM. OPERATION PROFILE 55 A

NAME <u>LENN FORD</u>		ALG <u>00</u>		DATE <u>5-30-89</u>		RCC <u>MANUFACTURING</u>		SHEET <u>OF</u>							
PCN <u>15-697A</u>		WCD <u>212220</u>		WCD DATE <u>890405</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED HRS.	DATA SOURCE COMMENTS			
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.			EQUIPMENT CODE	QTY.	
50	MAN PWW	LOAD	1.30	TRANSIT			WFO8	2	3.3	CE27	1	1.0	UNLOAD 10/ SACK 20/ LOAD		
				SETUP											
				PROCESS											
50A	MAN PWW	HEAT	.30	TRANSIT									HEAT 10/ COIL		
				SETUP											
				PROCESS											
50B	MAN PWW	UNLOAD	.30	TRANSIT			WFO8	2	3.3	CE27	1	1.0	REMOV FROM		
				SETUP											
				PROCESS											
50C	MAN PWW	COOL DOWN	.30	TRANSIT									AIR Time		
				SETUP											
				PROCESS											
50D	MAN PWW	UNLOAD	.30	TRANSIT			WFO8	2	3.3	CE27	1	1.0	UNLOAD FROM RACK		
				SETUP											
				PROCESS											

OPERATIONAL PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 2

WCD 2/20/89 WCD DATE 89054

OPERATION NUMBER 15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
40	MAN PGW	LOAD	1.0	TRANSIT							
				SETUP							
				PROCESS							
40A	MAN PNA	FPI	.25	PROCESS	KI07	1	.05	PM 0901	1	.05	
				TRANSIT				PM 0901	1	.02	
				PROCESS				PM 0901	1	1.10	
40B	MAN PNA	FPI	.75	PROCESS	DB09	1	.10	PM 0679E	1	1.10	
				TRANSIT				PM 0901	1	.02	
				PROCESS		2	.05	PM 0679E	1	1.05	
40C	MAN PGW	UNLD	1.0	TRANSIT				PM 0901	1	.05	
				PROCESS	KI07	1	.05	PM 0901	1	.05	

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 2

WCD 21203N WCD DATE 89054

15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					Skill Code/Level	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
70	MAN PGW	LOAD	.30	TRANSIT							
				SETUP							
				PROCESS							
70A	MAN PNA	FPI	.08	TRANSIT	KI07	1	.05	PM 0901	1	.05	
				PROCESS							
				PROCESS							
70B	MAN PNA	FPI	.23	TRANSIT							
				PROCESS							
				PROCESS							
70C	MAN PGW	UNLD	.30	TRANSIT							
				PROCESS							
				PROCESS							

NAME CORNFORD ALO 100 DATE 5-30-89 RCC MANUFACTURING SHEET OFWCD 212030 WCD DATE 89054PCN 15693A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	
20	MAN PWW	LOAD	1.0	TRANSIT		WFO8 4504	2	1.3	CE27	1	1.0	UNLOAD FROM 10/57 BACK TO LOAD
				SETUP								
				PROCESS								
20A	MAN PWW	HEAT	1.0	TRANSIT								HEAT TO SECTION
				SETUP								
				PROCESS					PM6999	1	13.0	
20B	MAN PWW	UNLOAD	1.0	TRANSIT		WFO8 4504	2	1.3	CE27	1	1.3	REMOVES FROM
				SETUP								
				PROCESS								
20C	MAN PWW	COOL DOWN	1.0	TRANSIT								Air Time
				SETUP								
				PROCESS	1	15						
20D	MAN PWW	UNLOAD	1.0	TRANSIT		WFO8 4504	2	1.3	CE27	1	1.0	UNLOAD FROM BACK
				SETUP					LB9862	1	1.0	
				PROCESS					LB9851	1	1.0	

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 3

WCD 21204N WCD DATE 880813

CCN 15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKL. CODE/ LEVEL	QTY.	TIME REQUIRED %	QTY.	EQUIPMENT CODE	TIME REQUIRED %	
40	MAN PGW	LOAD	1.0	TRANSIT							
				SETUP							
				PROCESS							
				PROCESS	KI07	1	.05	1	PM 0901	.05	
40A	MAN PNA	FPI	.25	TRANSIT							
				PROCESS							
				PROCESS							
				PROCESS	DB09	1	.10	1	PM 0679E	1.10	
40B	MAN PNA	FPI	.75	TRANSIT							
				PROCESS							
				PROCESS							
				PROCESS	DB09	2	.05	1	PM 0679E	1.05	
40C	MAN PGW	UNLD	1.0	TRANSIT							
				PROCESS							
				PROCESS							
				PROCESS	KI07	1	.05	1	PM 0901	.05	

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 2

WCD 21204N WCD DATE 88083

PCN 15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					Skill Code/Level	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
70	MAN PGW	LOAD	.30	TRANSIT							
				SETUP							
				PROCESS							
				PROCESS	KI07	1	.05	PM 0901	1	.05	
70A	MAN PNA	FPI	.08	TRANSIT							
				PROCESS							
				PROCESS	DB09	1	.10	PM 0679E	1	.10	
				PROCESS							
70B	MAN PNA	FPI	.23	TRANSIT							
				PROCESS							
				PROCESS	DB09	2	.05	PM 0679E	1	.05	
				PROCESS							
70C	MAN PGW	UNLD	.30	TRANSIT							
				PROCESS							
				PROCESS	KI07	1	.05	PM 0901	1	.05	
				PROCESS							

VERY LUM.

OPERATION PROFILE

CSA

NAME CERNWORTH AL0 00 DATE 5-30-89 RCC MINUTEMAN SHEET OF

PCN

NSN

PIN 15198A

WCD 21204A

WCD DATE 8X187

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
20	MAN PWW	LOAD	1	TRANSIT		2	1.3	CE27	1	1.0	LOAD 311 WFS 10/STACIL 20/LOAD
				SETUP							
				PROCESS							
20A	MAN PWW	HEAT	1	TRANSIT							HEAT 110 WFS
				SETUP							
				PROCESS							
20B	MAN PWW	UNLOAD	1	TRANSIT		2	1.0	CE27	1	1.0	REMOVER FROM
				SETUP							
				PROCESS							
20C	MAN PWW	cool DOWN	1	TRANSIT							Air Time
				SETUP							
				PROCESS	15						
20D	MAN PWW	UNLOAD	1	TRANSIT		2	1.0	CE27	1	1.0	UNLOAD FROM RACK
				SETUP				LB985X	1	1.0	
				PROCESS				LB9851	1	1.0	

OPERA PROFILE

NAME Turner ALC 00 DATE 5-24-89 RCC MANPRA SHEET 1 OF 2

WCD 21206 N WCD DATE 89037

15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
040	MAN	Mach	1.00	TRANSIT		JA 10	1	.02				
	PRA			SETUP		JA 10	1	.51	PM 5268	1	.51	
				PROCESS		JA 10	1	.64	PM 5268	1	.64	
50	MAN	Mach	.01	TRANSIT		JA 10	1	.02				
	PRA			SETUP		JA 10	1	.51	PM 5268	1	.51	
				PROCESS		JA 10	1	.62	PM 5268	1	.62	
60	MAN	Thrd	.01	TRANSIT		JA 09	1	.02				Bench OP
	PRA			SETUP		JA 09	1	.28	PM	1		
				PROCESS		JA 09	1	.34	PM	1		
70	MAN	Thrd	.01	TRANSIT		JA 09	1	.02				Bench OP
	PRA			SETUP		JA 09	1	.56	PM	1		
				PROCESS		JA 09	1	.68	PM	1		
80	MAN	Thrd	.01	TRANSIT		JA 09	1	.02				Bench OP
	PRA			SETUP		JA 09	1	.56	PM	1		
				PROCESS		JA 09	1	.68	PM	1		

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 2

PCN NSH PIN		WCD				MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED			
								%	HRS.			%	HRS.		
90	MAN	Repe	1.00	TRANSIT		JA 10	1		.02						
	SETUP														
	PROCESS														
110	MAN	Inst.	1.00	TRANSIT		JA 10	1		.02						
	SETUP														
	PROCESS														
				TRANSIT											
	SETUP														
	PROCESS														
				TRANSIT											
	SETUP														
	PROCESS														
				TRANSIT											
	SETUP														
	PROCESS														

OPERATION PROFILE

NAME <u>NORMAN FLETCHER</u> ALC <u>CO-ALC</u> DATE <u>30 MAR 69</u> RCC <u>MANIPG/V</u> SHEET <u>1</u> OF <u>1</u>												
PCN <u>15698A</u> WCD <u>21206N</u> WCD DATE <u>09037</u>												
PIN <u>15698A</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
95 100	MAN PRC	MUNE	1.0	TRANSIT		UPD5	1	.6	FLCOOZ	1	.6	EXTERNAL MOVE T 36M
97 100	MAN PRC	CLN	1.0	TRANSIT		UPD5	1	.05	PM 411B	1	.05	DECREASE T 3M
				SETUP								S/P 6M
				PROCESS		UPD9	1	.1	CE33	1	.1	
				TRANSIT					PM 5620	1	.1	
				SETUP								
				PROCESS								
97A 100	MAN PRC	TEST BEEN	1.0	TRANSIT		UPD5	1	.05	PM 411B	1	.05	SHUT BEEN /MASK T 3M
				SETUP		UPD5	1	.1	CE22	1	.1	S 6M
				PROCESS					PM 5372	1	.1	P 3M
				TRANSIT								
				SETUP					CE22	1	.05	
				PROCESS		UPD5	1	.05	PM 5372	1	.05	

OPERATION PROFILE

NAME <u>NEUMAN FETTER</u> ALC <u>EXD-ALC</u> DATE <u>30 MAY 69</u> RCC <u>MANPGW</u> SHEET <u>2</u> OF <u> </u>												
PCH NSN PIN												
WCD <u>2120GN</u> WCD DATE <u> </u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
						SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED % HRS.
A 100X	MAN PRC	CLN ANZ2	1.0	TRANSIT		UP05	1	.05	PM 4118	1	.05	TU220
				SETUP		UP09	1	.05	CE20	1	.05	T 3 M S 3 M
				PROCESS					PM 5231	1	.05	P 5 M
-	-	-	-	TRANSIT								
				SETUP					CE20	1	.05	
				PROCESS		UP09	1	.05	PM 5231	1	.05	
100B 100D	MAN PRC	RINS ANZ2	1.0	TRANSIT								RINSE
				SETUP		UP09	1	.01	CE20	1	.01	T/S 1 M
				PROCESS		UP09	1	.01	CE20	1	.01	P 1 M
-	-	-	-	TRANSIT								
				SETUP					PM 5270	1	.01	
				PROCESS								
100C 100E	MAN PRC	CLN ANZ2	1.0	TRANSIT								FORMULA PR
				SETUP		UP09	1	.01	CE20	1	.01	T/S 1 M
				PROCESS		UP09	1	.01	CE20	1	.01	P 1 M

OPERATION PROFILE

NAME <u>NOVIA L FETTER</u> ALC <u>CC-AIC</u> DATE <u>30 MAY 69</u> RCC <u>MANPCW</u> SHEET <u>3</u> OF <u> </u>															
PCN <u> </u> NSN <u> </u> PIN <u> </u>															
WCD <u>21206N</u> WCD DATE <u> </u>															
MANPOWER															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOTT HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT		DATA SOURCE COMMENTS		
					%	HRS.			%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.
-	-	-	-	TRANSIT	-	-	-	-	-	-	-	PM 5693	1	.01	
-	-	-	-	SETUP	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	PROCESS	-	-	-	-	-	-	-	-	-	-	-
100D	MAN	RINS	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	RINSE
100E	MAN	ANZ2	1.0	SETUP	-	-	-	UP09	1	-	.01	CE20	1	.01	T/S IM
-	-	-	-	PROCESS	-	-	-	UP09	1	-	.01	CE20	1	.01	P IM
-	-	-	-	TRANSIT	-	-	-	-	-	-	-	PM 5670	1	.01	-
-	-	-	-	SETUP	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	PROCESS	-	-	-	-	-	-	-	-	-	-	-
100E	MAN	ANZ2	1.0	TRANSIT	-	-	-	-	-	-	-	-	-	-	DECK/DEIZE
100G	MAN	ANZ2	1.0	SETUP	-	-	-	UP09	1	-	.01	CE20	1	.01	T/S IM
-	-	-	-	PROCESS	-	-	-	UP09	1	95	05	PM 5707	1	95	P 5M 95 IDM 05
-	-	-	-	TRANSIT	-	-	-	-	5	08	-	-	-	5	17
-	-	-	-	SETUP	-	-	-	-	-	-	-	CE20	-	95	05
-	-	-	-	PROCESS	-	-	-	-	-	-	-	-	-	5	08

OPERATION PROFILE

NAME NORMAN FLETCHER ALC COALC DATE 30 MARCH RCC MANPGW SHEET 4 OF 4

PCN _____ WCD <u>Z1Z06N</u> WCD DATE _____												
PCN NSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
						%	HRS.	SKILL CODE/ LEVEL		%	HRS.	
F 100X	MAN PRC	RINS ANZL	1.0	TRANSIT	TRANSIT							RINSE T/S IM P IM
					SETUP	UP09	1	.01	CEZ0	1	.01	
					PROCESS	UP09	1	.01	CEZ0	1	.01	
				TRANSIT	TRANSIT				PM SETUP	1	.01	
					SETUP							
					PROCESS							
G 100X	MAN PRC	ANZL	1.0	TRANSIT	TRANSIT							SURFACE ANODIZE T/S IM P 45m
					SETUP	UP09	1	.01	CEZ0	1	.01	
					PROCESS	UP09	1	.05	CEZ0	1	.05	
				TRANSIT	TRANSIT				PM SETUP	1	.75	
					SETUP							
					PROCESS							
H 100X	MAN PRC	RINS ANZL	1.0	TRANSIT	TRANSIT							RINSE T/S IM P IM
					SETUP	UP09	1	.01	CEZ0	1	.01	
					PROCESS	UP09	1	.01	CEZ0	1	.01	

PM 5702 1 .01

OPERATION PROFILE

NAME NOVIAN FETTER ALC CC ALC DATE 30 MAR 1979 RCC MAN POW SHEET 5 OF

PCN NSN P/N		WCD 212000N		WCD DATE		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.			%	HRS.	
I 100K	MAN PCC	SEAL ANZZ	1.0	TRANSIT										SEAL T/S IM P 5M.75 15M.25	
				SETUP			UP09	1		.01	CE20	1			.01
				PROCESS			UP09	1	95	.05	CE20	1	95		.25
-	-	-	-	TRANSIT					5	.10			5	.10	
				SETUP						PM 5673	1	95	.08		
				PROCESS								5	.25		
J 100K	MAN PCC	RINS ANZZ	1.0	TRANSIT										RINSE T/S IM P 1M	
				SETUP			UP09	1		.01	CE20	1			.01
				PROCESS			UP09	1		.01	CE20	1			.01
-	-	-	-	TRANSIT							PM 5700	1		.01	
				SETUP											
				PROCESS											
K 100M	MAN PCC	RINS ANZZ	1.0	TRANSIT										RINSE, HOT T/S IM P 1M	
				SETUP			UP09	1		.01	CE20	1			.01
				PROCESS			UP09	1		.01	CE20	1			.01

PM 5676 1 .01

OPERATION PROFILE

NAME <u>MEL ANDERSON</u> ALC <u>00</u> DATE <u>5-31-89</u> RCC <u>MANPGW</u> SHEET <u>1</u> OF <u>1</u>												
WCD <u>21206N</u> WCD DATE <u>89037</u>												
P/N <u>15698A</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	MANPOWER QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
15	MAN PNA	FPI	.75	TRANSIT					PM	1	.02	
				PROCESS								
				PROCESS								
15A	MAN PNA	FPI	.25	TRANSIT					PM	1	.02	
				PROCESS								
				PROCESS								
16	MAN PGW	UNLD	1.0	TRANSIT					PM	1	.05	
				PROCESS								
				PROCESS								
18	MAN PNA	COND	1.0	TRANSIT					PM	1	.05	
				PROCESS								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

OPERATIONAL PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

WCD 21207N WCD DATE 89131
 15698A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
15	MAN PGW	LOAD	1.0	TRANSIT												
				SETUP												
				PROCESS												
				PROCESS			KI07	1		.05	PM 0901	1		.05		
15A	MAN PNA	FPI	.25	TRANSIT												
				PROCESS												
				PROCESS												
				PROCESS			DB09	1		.10	PM 0679E	1		1.10		
15B	MAN PNA	FPI	.75	TRANSIT												
				PROCESS												
				PROCESS												
				PROCESS			DB09	2		.05	PM 0679E	1		1.05		
15C	MAN PGW	UNLD	1.0	TRANSIT												
				PROCESS												
				PROCESS												
				PROCESS			KI07	1		.05	PM 0901	1		.05		

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

PCN		NSN		PM		WCD		Z1209N		WCD		DATE		89040				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS			
					%	HRS.			%	HRS.	EQUIPMENT CODE	QTY.						
				TRANSIT														
				SETUP														
				PROCESS														
14	MAN PNA	MAG	1.0	TRANSIT			OVHD	1										
				PROCESS														
14A	MAN PNA	DEGR	1.0															
				PROCESS														
				TRANSIT			DB09	1										
				SETUP														
				PROCESS														
				TRANSIT														
				SETUP														
				PROCESS														

OPERATION PROFILE

NAME <u>KERSHAN</u> ALC <u>00</u> DATE <u>6-1-89</u> RCC <u>Brakes</u> SHEET <u>1</u> OF <u> </u>		WCD <u>21208N</u> WCD DATE <u>89040</u>		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS		
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		QTY.	TIME REQUIRED	
								%	HRS.			%
30	MAN RGP	Assy	1.0	TRANSIT								Assemble Brakes
				SETUP								
				PROCESS								
40	/	Test	1.0	TRANSIT								Test & Decals
				SETUP								
				PROCESS								
60	/	Acp	1.0	TRANSIT								Acceptance of paperwork
				SETUP								
				PROCESS								
070	/	Insp	1.0	TRANSIT								Final Visual Inspection
				SETUP								
				PROCESS								
	/			TRANSIT								
				SETUP								
				PROCESS								

C-5 RGM

1.50-200020

OPERATION PROFILE

NAME Kyle ALC DATE 21206N RCC Brake SHEET 1 OF 3

WCD 21206N WCD DATE 89037

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %		
120	MAN PAP	Insp	1.0	TRANSIT		1			F1001	1		Inspect parts
				SETUP								
				PROCESS		1			Pm0932	1		check paper
130		LOAD	1.0	TRANSIT								Load paint line
				SETUP								
				PROCESS		1			Pm0922	1		
130A		UNSH	1.0	TRANSIT								solvent wash
				SETUP		1			Pm0922	1		
				PROCESS					Pm0926	1		
130B		Aug	1.0	TRANSIT								Plug & mask
				SETUP								
				PROCESS		1			Pm0922	1		
130C		Prim	1.0	TRANSIT								Prime + Dry
				SETUP	1				Pm0922	1		
				PROCESS					Pm0928	1		

C-5 Housing

OPERATION PROFILE

NAME VERSHAW ALC _____ DATE _____ RCC _____ SHEET 2 OF 23

WCD 21206N WCD DATE 89037

OPERATION NUMBER	MCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
130D	WPN RGP	Paint	1.0	TRANSIT											1st paint	
				SETUP			3009	1		.02	Pm0922	1		.02		
				PROCESS							Pm0436	1		.02		
130E		Paint	1.0	TRANSIT											2nd paint	
				SETUP		.5	3009	1		.02	Pm0922	1		.5		
				PROCESS							Pm0437	1		.02		
130F		UNLD	1.0	TRANSIT											UNLOAD to strip	
				SETUP							Pm0922	1		.01		
				PROCESS			Y609	1		.02	Pm0928	1		.02		
130A		Rep	1.0	TRANSIT											Rebuild cylinders & pistons & adjusters	
				SETUP												
				PROCESS			Y609	1		2	W00006	1		2		
140		Rep	1.0	TRANSIT											Acceptance of paperwork	
				SETUP												
				PROCESS			Y609	1								

C-5 Housing

* Note - No 1.0 in same time item

OPERATION PROFILE

NAME KERSHAW ALC 00 DATE 2/20/06 RCC MANAGER-Bakes SHEET 3 OF 3

WCD 21206 WCD DATE 89037

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %	
150	P&P	IWP	1.0	TRANSIT							Final Visual IWP
				SETUP							
				PROCESS		4009	1			.02	
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

C-5 Housing

OPERATION PROFILE

NAME <u>Keshawn</u>		ALC		DATE		RCC <u>WNNPSP-Bakes</u>		SHEET <u>2</u> OF <u>2</u>							
PCN <u>15698A</u>		WCD <u>21202N</u>		WCD DATE <u>8/04/5</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.				
110	PSP	Acpt	1.0	TRANSIT											Acceptance of paperwork
				SETUP											
				PROCESS											
120	PSP	Insp	1.0	TRANSIT											Final Visual Insp
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

1-5 Station

OPERAT PROFILE

NAME KESHAW ALC _____ DATE _____ RCC _____ SHEET 1 OF 2

WCD 21203N WCD DATE 870415 89034

PIN 12012H		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED			
					%	HRS.			%	HRS.			%	HRS.		
80	MAN REP	Insp	1.0	TRANSIT			0VHD	1			.01	FLOOD	1		.01	Inspect post and load paint line
				SETUP												
				PROCESS			3009	1		.02	PM022	1		.02		
90		Prim	1.0	TRANSIT												Prime & Dry
				SETUP		25	3009	1		.01	PM022	1		.25		
				PROCESS							PM028	1		.01		
90A		UNLD	1.0	TRANSIT												unload
				SETUP			4009	1		.01	PM022	1		.01		
				PROCESS							PM028	1		.01		
100		RIND	1.0	TRANSIT												Ruck, Center and
				SETUP												
				PROCESS			4009	1		.07	PM733	1		.07		
100A		RIND	1.0	TRANSIT												Ruck Inside Row
				SETUP												
				PROCESS			4009	1		.1	PM5763	1		.1		

C-5A ~~Station~~ Robot

OPERATION PROFILE

NAME <u>FRANK</u>		ALC _____		DATE _____		RCC _____		SHEET <u>2</u> OF <u>2</u>				
PCN <u>150984</u>		WCD <u>21203N</u>		WCD DATE <u>89054</u>								
NSN <u>PM</u>		WCD <u>21203N</u>		WCD DATE <u>89054</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
110	PSP	Apt	1.0	TRANSIT SETUP PROCESS								Acceptance of paperwork
120	PSP	Insp	1.0	TRANSIT SETUP PROCESS			1	.02				Final Visual Inspection
				TRANSIT SETUP PROCESS			1	.02				
				TRANSIT SETUP PROCESS								
				TRANSIT SETUP PROCESS								
				TRANSIT SETUP PROCESS								

End date

OPERATION PROFILE

NAME KEITH ALC Brakes SHEET 2 OF 2

WCD 21204N WCD DATE 88083

PCN 15678A

OPERATION NUMBER		ROC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%
130	PGP	Acp +	1.0		TRANSIT									Acceptance of paperwork	
					SETUP										
					PROCESS			Y609	1		.02				
140	PGP	Insp	1.0		TRANSIT									Final Visual Inspected.	
					SETUP										
					PROCESS			Y609	1		.02				
					TRANSIT										
					SETUP										
					PROCESS										
					TRANSIT										
					SETUP										
					PROCESS										
					TRANSIT										
					SETUP										
					PROCESS										
					TRANSIT										
					SETUP										
					PROCESS										

C-5 End p1f

OPERATION PROFILE

NAME KERSTAN ALC _____ DATE _____ RCC Bakes SHEET 1 OF 1

WCD 21210N WCD DATE 87040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.			%	HRS.			%	HRS.	
010	MIN 24P	MATCH	1.0	TRANSIT											MATCH UP
				SETUP											
				PROCESS											
020		ASSY	1.0	TRANSIT											Assembly
				SETUP											
				PROCESS		Y609	1		.33	W10005	1	.33			
030		INSP	1.0	TRANSIT											Final Insp. & paperwork
				SETUP											
				PROCESS		Y609	1		.07	W10005	1	.07			
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

C-5 Torque tube

02

OPERATION PROFILE

NAME <u>KERSHAW</u>		ALC _____		DATE _____		RCC _____		SHEET <u>1</u> OF <u>1</u>						
WCD <u>21207N</u>		WCD <u>21207N</u>		WCD DATE <u>89131</u>										
PCN <u>15698A</u>		NSN _____		PN _____										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS		
050	RGP	Apt	1.0	TRANSIT		DUHD	1	.03	F1002	1	.03	Acceptance of paperwork		
				SETUP										
				PROCESS										
060	RGP	Insp	1.0	TRANSIT								Final Visual Insp		
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

1) B B #4

C130 B.1.1

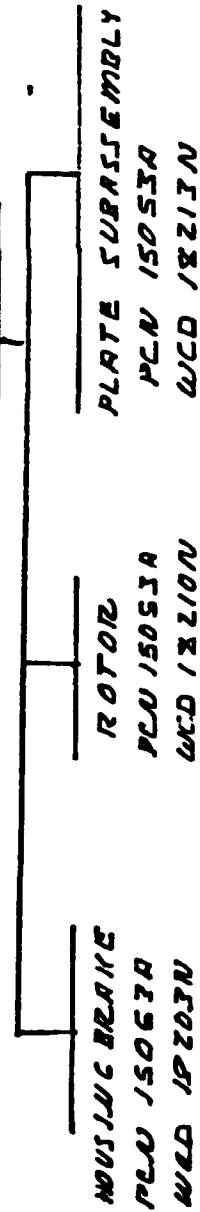
13

C 130
BRAKE
ASSY

C 130 BRAKE ASSY

PCN 15053A

WCD 18214A



CODE NAME AND ADDRESS

21849 NASCO Engineering Inc
13300 Estrella Ave
Gardena, CA 90247

72902 Greene Tweed and Co Inc
320 Elm Ave
North Wales, PA 19454-3332

73842 Goodyear Tire & Rubber Co
1144 E Market
Akron, OH 44316

CODE NAME AND ADDRESS

83512 Nylok Fastener Corp
611 Industrial Ave
PO Box 314
Paramus, NJ 07652-3606

88044 Aeronautical Standards Group
Dept of Navy and Air Force

96906 Military Standards

98747 Ogden Air Logistics Center
Hill AFB, UT 84056

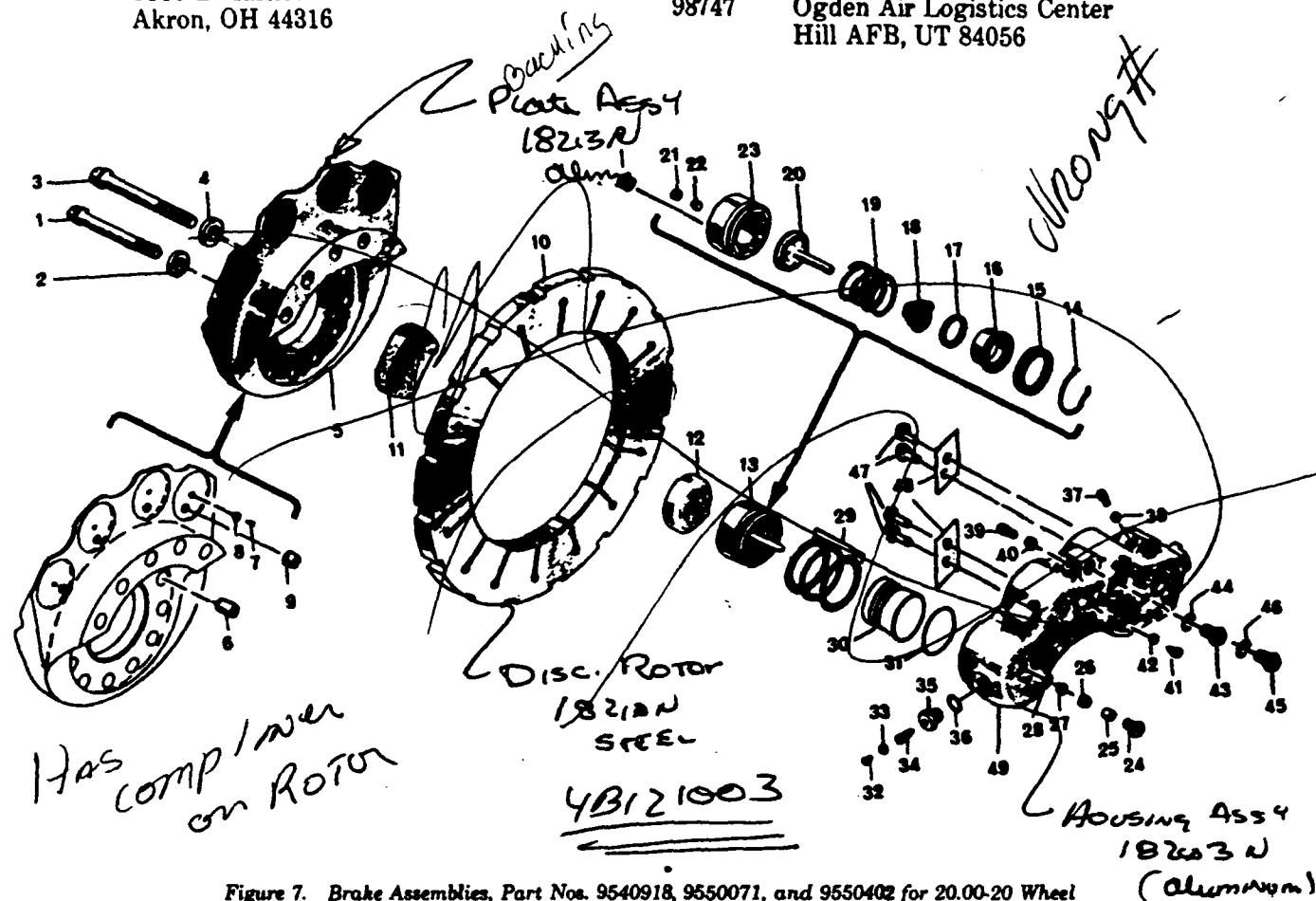


Figure 7. Brake Assemblies, Part Nos. 9540918, 9550071, and 9550402 for 20.00-20 Wheel

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
7.	9540918		BRAKE ASSEMBLY, For 20.00-20 wheel (mag)							1	A	PA000
	9550071	73842	BRAKE ASSEMBLY, For 20.00-20 wheel (mag/alum), use until exhausted							1		PA000
	9550402	73842	BRAKE ASSEMBLY, For 20.00-20 wheel (alum)							1		PA000
.1	9522416	73842	BOLT, Internal wrenching							2		PAFBZ
.2	9522212	73842	WASHER, Countersink							2		PAFBZ
.3	9522415	73842	BOLT, Internal wrenching							3		PAFBZ
.4	9522213	73842	WASHER, Countersink							3		PAFBZ
.5	9531116	73842	PLATE SUBASSEMBLY, (Mag) HB, use on brake assy 9540918 only							1	A	PADDD
	9532797	73842	PLATE SUBASSEMBLY, HB alum							REF		XA

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
7-5	9550008									1	B	PADDD
-6	9522063	73842								12	A	PAFZZ
-7	MS20427-5C10	# 96906								4		KF
-8	9521519	# 73842								4		KF
-9	66C33001-109A									AR	B.D	
	66C33001-109S									AR	A.C	
-10	9531109	73842								1		PADDD
	31301	21849										PADDD
-11	9531369	# 73842								4		KF
-12	9531368	# 73842								4		KF
-13	9525271	73842								4		PAFDD
-14	9511058	73842								1		PAFBZ
-15	9522057	73842								1		PAFBZ
-16	9522056	73842								1		PAFBZ
-17	511820-10	# 73842								1		KF
-18	9510341	73842								1		PAFBZ
-19	512132	73842								1		PAFBZ
-20	9522023	73842								1		PAFBZ
-21	9521958	73842								1		KF
-22	9522022	73842								1		KF
-23	9532801	73842								1	C	PAFDD
	7430500	73842								1	D	PAFDD
-24	9521702	# 73842								4		KF
-25	9522214	# 73842								4		KF
-26	9510943	# 73842								4		KF
-27	7329137-01	#** 98748								4		KF
-28	MS28775-012	88044								4		PAFZZ
-29	33A7MS-160-P4	72902								4		PAFZZ
-30	68C29675-01	98747								4		PAFBZ
-31	MS28775-238	** 96906								4		PAFBZ
	723C8FR-987-P4	** 72902								4		PAFBZ
-32	AN501A10-5	# 88044								2		KF
	MS35266-60	88044								2		PAFBZ
-33	511846-4	# 73842								2		KF
-34	AN6204-1	88044								2		PAFBZ
-35	9533594	73842								2		PAFBZ
-36	MS28778-8	96906										
-37	AN502-516-12	# 84044								4		KF
	AN5H4A									4		PAFBZ
-38	511846-5	# 73842								4		KF
-39	9522211	# 73842								2		KF
	AN5H4A									2		PAFBZ
-40	511846-5	73842								2		PAFBZ
-41	AN502-10-6	88044								4		PAFBZ
-42	511846-4	73842								4		PAFBZ
	AN935-10L	88044								4		PAFBZ
	MS35338-43	88044								4		PAFBZ
-43	511589	73842								1		PAFBZ
-44	MS28778-8	96906								1		PAFZZ
-45	1604-78	# 79555								1		KF
-46	MS28778-6	96906								1		PAFBZ
-47	NK509-10R7F	83512								AR		PAFBZ
-48	7027183-01	** 98747								2		PAFBZ
-49	9550069	73842								1		PADDD

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CLDE
7-50	9500328-1	73842	KIT, Field.....	1		PAFBZ

*At the time of overhaul, remove magnesium plate subassembly, part No. 9531116, from brake assembly, part No. 9550071, and replace with aluminum plate subassembly, part No. 9550008. Reidentify as brake assembly, part No. 9550402, on brake housing, part No. 9550069, raised assembly pad, by grinding off the last three digits of old part number and restamp with 402. Use 1/8 inch metal stamp.

**Order separately. Not supplied as part of brake assembly, for repair only.

*These parts are furnished as part of field kit, part No. 9500328-1.

Housing Assy: 18203N ; Aluminum

(PAT ALEXANDER)

- 5 DIS (REMOVE PISTON SUB ASSY WITH LINER)
 5a REM (LOCKING PLATES)
 7a LOAD (OH. CONVEYOR)
 7 CLN (Chem Clean)
 7b TRANS (TO BLAST AREA VIA O.H. CONVEYOR)
 9a UNL (OH CONVEYOR)
 9 CLN (BLAST CLEAN)
 9b STACK (on pallet & pw)
 12a LOAD (OH. CONVEYOR)
 12 PROC (ANODIZE STRIP)
 12b TRANS (TO FPT INSP. PROCESS)
 19a UNL (O.H. CONVEYOR)
 19L PROC (NICK & BURR)
 19b LOAD (CONVEYOR TO E&I)
 20 INSP (E&I)
 20a MOVE (TO WELD SHOP)

PLATE ASSY Alum

- 5 DIS (REMOVE LINERS)
 7a LOAD (OH CONVEYOR)
 7 CLN (CHEM CLEAN LINE)
 7b TRANS (TO BLAST AREA VIA OH CONVEYOR)
 9a UNL (OH CONVEYOR)
 9 PROC (BLAST)
 12a LOAD (OH CONVEYOR)
 12 PROC (STRIP ANODIZING)
 12b TRANS (OH. CONVEYOR TO ANOD. PROC)
 19a UNL (OH. CONVEYOR)
 19 PROC (NICK & BURR)
 19b TRANS (TO E&I)
 20 INSP (E&I)
 20a STACK (on pallet)
 20b MOVE (TO MACH SHOP)

ROTOR 18210N } STEEL

- S - O/S (FOREIGN MAT'L)
- 5b - STACK (pallet)
- 8a - LOAD (ROTOR BLAST)
- 8 - PROC ROTOR BLAST
- 8b - STACK (on pallet)
- 8c - MOVE (TO FMPI)
- 20 - INSP (E&I THICKNESS)
- 20a - STACK (pallet)
- 20b - MOVE (TO SYNDIAS)

C-130A Brake

(G402A-TIP001)

LABOR STD REVIEW 14, APR, 89

7:58 AM

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	FACTORED STAND HOURS
15053A	MNFGP	00010	E	YG	5	1.34	1.00	1.34
		PM214	N	YG	5	.58	1.00	58
		PP203	N	3S	5	.33	1.00	33
		PP213	E	3S	5	.08	1.00	8
		PS203	E	YG	5	.02	1.00	2
		PS210	E	YG	5	.02	1.00	2
		PS213	E	YG	5	.02	1.00	2
		PT214	N	YG	5	.41	1.00	41

		*						2.80
	MNFGW	WC001	E	KI	5	.59	1.00	59
		WD001	E	HB	5	.99	1.00	99
		WE203	N	DI	5	.36	1.00	36
		WE210	E	DI	5	.39	1.00	39
		WE213	N	DI	5	.25	1.00	25

		*						2.58
	MNFMG	MG203	N	JB	1	.50	.05	2

		*						2
	MNPMN	MN203	N	JA	1	.66	1.00	66

		*						66
	MNPNNA	NA210	E	DB	2	.28	1.00	28

15053A ~C130 BRAKE 9550402

RCC NPRA

481-2-133

OPER TECH S S W F PF A/R REV

SUB	T K	NR A FA	SUPPORT	DOC	DESCRIPTION	BASE	PFD	STD	DLY
STEP	D L	K C	DC	ELEMENT	FACT	HOURS	TIME	HOURS	PER C
RA203	S	E	JA	EA 1	J 89081	1.00			
0001			JA	01 00	.00	PERCENT ENGR 99.9			
0010					9550069	MACHINE BRAKE HOUSING C130	1.12	1.12	
0060			JA	01 15	.05	PART NUMBER/NSN	.000	.000	.000
0010 E					1630000556747				0
0020 E					MACHINE CAVITY	.668	.005	.038	3
0030 E					.25 S/U VERT MILL BORE SMAL EXTRAPRORATE OVER 4 PARTS	.50518		.145	
0040 E					RML-HP-CA 1.00 HAND HANDLE NO WRAP 2 CLAMPS	.08531		.098	
0050 E					RML-AL-AB 1.00 ALIGN VERTICAL AXIS ROD	.12599		.146	
0060 E					RML-AL-AC 1.00 ALIGN HOLE TO SPINDLE ROD	.07609		.087	
0070			JA	01 15	.10	KMM-BA-FD 1.00 BORE HOLE 3.5 X 2 GROUP 1 USE PROPER ELEMENT/TABLE	.24399		.280
0010 E					RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
0020 E					DRILL AND TAP INLET PORT	.486	.007	.056	5
0030 E					RDR-SU-R1 .50 S/U TO O/S BOSSES RAD DRILL	.56378		.324	
0040 E					KML-DR-VD 1.00 DRILL HOLE 1/2-2 DIAM 1.5-2	.17738		.203	
0050 E					KTL-TT-01 1.00 TAP THREADS 1ST HOLE 1ST THD	.00656		.007	
0060 E					KTL-TT-03 8.00 TAP EACH ADDITIONAL THREAD 8 ADNL THREADS	.00130		.011	
0070			JA	01 15	.10	RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011
0010 E					DRILL & TAP BLEEDER PORT	.486	.007	.056	5
0020 E					RDR-SU-R1 .50 S/U TO O/S BOSSES RAD DRILL	.56378		.324	
0030 E					KML-DR-VD 1.00 DRILL HOLE 1/2-2 DIAM 1.5-2	.17738		.203	
0040 E					KTL-TT-01 1.00 TAP THREADS 1ST HOLE 1ST THD	.00656		.007	
0050 E					KTL-TT-03 8.00 TAP EACH ADDITIONAL THREAD 8 ADNL THREADS	.00130		.011	
0060			JA	01 15	.05	RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011
0010 E					ASSEMBLY BOLT HOLE REPAIR	.473	.004	.027	
0020 E					PROGRATE OVER 4 PARTS	.18669		.053	
0030 E					RLG-HP-V7 5.00 OBJ IN/OUT STP VISE-HST HAND	.06831		.392	
0040 E					GTL-TH-A1 5.00 TAP HOLE TO 0.25 IN THRD DIA	.01427		.082	
0050 E					RBW-DB-A1 1.00 DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0060			JA	01 15	1.00	RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011
0010 E					OVERSIZE HOLE WITH REAPER	.349	.052	.402	36
0020 E					PROGRATE OVER 4 PARTS	.18669		.053	
0030 E					RLG-HP-V7 1.00 OBJ IN/OUT STP VISE-HST HAND	.06831		.078	
0040 E					RBW-BU-R2 3.00 REAM WITH LEMPCO REAMER 3 PASSES	.07337		.253	
0050 E					RBW-DB-A1 1.00 DEBUR HOLE/CUTOUT BOTH SIDES	.00423		.004	
0060			JA	01 00	1.00	RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011
0010 E					CHECK HELICOILS	.148	.000	.149	13
0020 E					RBW-SU-S1 .50 S/U FOR BENCH WORK GENERAL	.27525		.137	
0030 E					KAL-SC-46 1.00 INSPECT VISUAL	.00115		.001	
0040			JA	01 15	1.00	RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.010
0010 E					INSTALL HELICOILS	.348	.052	.401	36
0020 E					RBW-SU-H1 1.00 SET UP TO INSTALL HELICOILS	.31093		.357	
0030 E					RBW-TR-H1 1.00 INSTALL HELICOIL INSERT	.02763		.031	
0040			JA	01 00	.00	RJP-PW-R1 1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011
9000					LABOR STANDARD HISTORY	.000	.000	.000	0
0010					9 JUNE 86 INITIAL INPUT MRF11				
0900					NED MONROE MANEL 73255 MR BIG				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

1234567890123456

ELSE PUT IN END

15053A C130 BRAKE 9550402

RCC MNPRA

481-2-133

OPER TECH S S W F PF A/R REV

SUB T K #R A FA SUPPORT OCC <----- DESCRIPTION ----->

STEP D L K C DC ELEMENT FACT STORED SUPPLEMENTAL

BASE PFD STD A
HOURS TIME HOURS DLY PCT C

RA213	E	N	JA	EA	1	J	89081	.05	PERCENT ENGR 39.8	MACH PLATE SUBASSY C130	.78		.03		
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010							9550008			1630009972090					
0030			JA	01	15			1.00		MACHINE RADIUS	.552	.083	.636		81
0010	E						RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962		.143		
0020	E						RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006		.011		
0030	N							1.00		MACHINE RADIUS	.40800		.449		
0040	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0040			JA	01	15			.20		MACH ALIGNMENT HOLE	.459	.014	.106		14
0010	E						RDR-SU-R1	.25	S/U TO O/S BOSSES RAD DRILL	PRORATE OVER 4 PARTS	.56373		.162		
0020	E						RDR-B0-A1	1.00	O/S BOSS W/STEP RMR RAD DRL		.30463		.350		
0030	E						R3W-DB-A1	1.00	DEBUR HOLE/CUTOUT BOTH SIDES		.00423		.004		
0040	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
0080			JA	01	15			.20		INST ALIGNMENT HOLE BUSH	.167	.005	.039		5
0010	E						REW-BU-S1	.25	SET UP TO REBUSH BOSSES	PRORATE OVER 4 PARTS	.18669		.053		
0020	E						REW-BU-B2	.50	REBUSH A SET OF 2 BOSSES	1 BUSHING	.22231		.127		
0030	E						RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011		
9000			JA	01	00			1.00		LABOR STANDARD HISTORY	.000	.000	.000		0
0900									C. W. RIGBY MANEL-1	73357					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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1234567890123456 ELSE PUT IN END

MMPRB15053ARB210

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MMPRB

04/05/89
4B1-2-133

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15053A C130 BRAKE 9550402

OPER TECH S S W F PF A/R REV

SUB T K BR A FA SUPPORT OCC
STEP D L K C DC ELEMENT FACT

DESCRIPTION
STORDED SUPPLEMENTAL

BASE PFD STD
HOURS TIME HOURS DLY PCT C

R8210	S	E	JA	EA	1	J	89081	.75	PERCENT ENGR	99.9	GRIND ROTOR C130	1.74		1.30		
0001			JA	01	00			.00			PART NUMBER/NSN	.000	.000	.000		0
									9531109		1630003045430					
									31301		1630003045430					
0030			JA	01	15			1.00			GRIND ROTOR	1.514	.227	1.741		100
0010	E						RGR-SU-S1	1.00	SET UP SURFACE GRINDER			.04390		.050		
0020	E						RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS			.08531		.098		
0030	E						KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL			.02308		.026		
0040	E						KMG-GW-LK	1.00	LOCATE WHEEL TO POSITION			.06761		.077		
0050	E						KMG-OD-VA	2.00	GRIND .010 FROM 16 OD X 1	BOTH SIDES		.53334		1.226		
0060	E						RGR-GE-D2	16.00	DWELL (GAP GRINDER STEEL OD)	OCC FOR DIA		.01014		.186		
0070	E						RTL-MM-M3	9.00	MIC O D FIRST MEASUREMENT	3 PLACES 3 CHECKS		.00616		.063		
0080	E						RJP-PW-R1	1.00	REM RPL PAPWRK SIGN OFF DOC			.01001		.011		
9000			JA	01	15			1.00			LABOR STANDARD HISTORY	.000	.000	.000		0
0900									C. W. RIGBY MANEL-1	73357						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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1234567890123456 ELSE PUT IN END

2HNP1N15053AHN203

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC HNP1N

04/05/89
481-2-133

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15053A C130 BRAKE 9550402

OPER TECH S S W F PF A/R REV

SUB T K #R A FA SUPPORT OCC <----->

STEP D L K C DC ELEMENT FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURS

PFD
TIME

STD
HOURS

DLY PCT C

MN203	E	N	JA	EA	1	J	89090	1.00	PERCENT ENGR	.9	MACH. BRAKE HOUSING C-130	.66		.66	
0001			JA	01	00			.00			PART NUMBER/NSN	.000	.000	.000	0
											9550069				
											1630000556747				
0110			JA	01	00			.35			BORE FSTN CAVITIES	1.510	.000	.529	80
0010	N							1.00			BORE & TAP	1.35000		1.350	
0020	N							.05			SHARPEN TOOLS	3.00000		.150	
0030	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.010	
0120			JA	01	00			.25			LOCK PLATES	.535	.000	.134	20
0010	N							1.00			DRILL AND TAP HOLE	.52500		.525	
0020	E					RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.010	
9000			JA	01	00			.00			LABOR STANDRD HISTORY	.000	.000	.000	0
0900											8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRP11				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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1234567890123456 ELSE PUT IN END

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
7-5	9550008									1	B	PADDD
6	9522063	73842								12	A	PAFZZ
7	MS20427-5C10	96906								4		KF
8	9521519	73842								4		KF
9	66C33001-109A									AR	B,D	
	66C33001-109S									AR	A,C	
-10	9531109	73842								1		PADDD
	31301	21849										PADDD
-11	9531369	73842								4		KF
-12	9531368	73842								4		KF
-13	9525271	73842								4		PAFDD
-14	9511058	73842								1		PAFBZ
-15	9522057	73842								1		PAFBZ
-16	9522056	73842								1		PAFBZ
-17	511820-10	73842								1		KF
-18	9510341	73842								1		PAFBZ
-19	512132	73842								1		PAFBZ
-20	9522023	73842								1		PAFBZ
-21	9521958	73842								1		KF
-22	9522022	73842								1		KF
-23	9532801	73842								1	C	PAFDD
	7430500	73842								1	D	PAFDD
-24	9521702	73842								4		KF
-25	9522214	73842								4		KF
-26	9510943	73842								4		KF
-27	7329137-01	98748								4		KF
-28	MS28775-012	88044								4		PAFZZ
-29	33A7MS-160-P4	72902								4		PAFZZ
-30	68C29675-01	98747								4		PAFBZ
-31	MS28775-238	96906								4		PAFBZ
	723C8FR-987-P4	72902								4		PAFBZ
-32	AN501A10-5	88044								2		KF
	MS35266-60	88044								2		PAFBZ
-33	511846-4	73842								2		KF
-34	AN6204-1	88044								2		PAFBZ
-35	9533594	73842								2		PAFBZ
-36	MS28778-8	96906										
-37	AN502-516-12	84044								4		KF
	AN5H4A									4		PAFBZ
-38	511846-5	73842								4		KF
-39	9522211	73842								2		KF
	AN5H4A									2		PAFBZ
-40	511846-5	73842								2		PAFBZ
-41	AN502-10-6	88044								4		PAFBZ
-42	511846-4	73842								4		PAFBZ
	AN935-10L	88044								4		PAFBZ
	MS35338-43	88044								4		PAFBZ
-43	511589	73842								1		PAFBZ
-44	MS28778-8	96906								1		PAFZZ
-45	1604-78	79555								1		KF
-46	MS28778-6	96906								1		PAFBZ
-47	NK509-10R7F	83512								AR		PAFBZ
-48	7027183-01	98747								2		PAFBZ
-49	9550069	73842								1		PADDD

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
7-50	9500328-1	73842	. KIT, Field.....							1		PAFBZ

*At the time of overhaul, remove magnesium plate subassembly, part No. 9531116, from brake assembly, part No. 9550071, and replace with aluminum plate subassembly, part No. 9550008. Reidentify as brake assembly, part No. 9550402, on brake housing, part No. 9550069, raised assembly pad, by grinding off the last three digits of old part number and restamp with 402. Use 1/8 inch metal stamp.

**Order separately. Not supplied as part of brake assembly, for repair only.

*These parts are furnished as part of field kit, part No. 9500328-1.

STL-STEEL
AL-ALUMINUM
MAG-MAGNESIUM
TITA-TITANIUM
SS-S STL
SYN-SYNTHETIC
LD-LEAD

C130 ML6 BRACE ASSY
BILL OF MATERIALS
15053A

[illegible]

7MNPNA13053ANA210

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

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9550402

RCC MNPNA

481-2-133

OPER TECH S S W F PF A/R REV

SUB	T K	NR A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP D L	K C DC	ELEMENT	FACT	STOR	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

NA210	S	E	DB	EA	2	J 89081	1.00	PERCENT ENGR 99.9	NDI ROTOR C130 BRAKE	.28		.28	
0001			DB	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
	0010					9531109			1630003045430				
	0020					31301			1630003045430				
0040			DB	01	11		1.00		FMP1 ROTATING DISK 19204N	.158	.017	.176	62
	0010	E				ZLG-ND-HS	1.00	MAGNAGLD INSP V/S OBJECT		.06113		.067	
	0020	E				RMB-CV-D1	1.00	VAPOR CL (DEGR)HOOK/BASKET		.08709		.096	
	0030	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0050			DB	01	11		1.00		DEGREASE	.097	.011	.108	38
	0010	E				RMB-CV-D1	1.00	VAPOR CL (DEGR)HOOK/BASKET		.08709		.096	
	0020	E				RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			DB	01	00		.00		LABOR STANDARD HISTORY	.000	.000	.000	0
	0010												
	0900												

08JAN85 2 YEAR REVIEW/NO TIME CHANGE
N MONROE/MANEAA

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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MMFNA15053ANA213

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

04/05/89

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15053A C130 BRAKE 9550402

RCC MMFNA

481-2-133

OPER	TECH	S	S	W	F	PF	A/R	REV											
SUB	T	K	#R	A	FA	SUPPORT	OCC	<-----	DESCRIPTION	----->	BASE	PFD	STD						
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED		SUPPLEMENTAL	HOURS	TIME	HOURS						A
NA213	S	E	DB	EA	2	J	89081	.05	PERCENT ENGR 99.9	NDI PLATE C130 BRAKE	.07		.00						
0001			DB	01	00			.00		PART NUMBER/NSN	.000	.000	.000						0
			0010					9550008		1630009972090									
0050			DB	01	11			1.00		CHECK IAW T/O	.064	.007	.072						100
			0020	E		RWB-CI-05	1.00	CHEM INSP-SMALL OBJ (ZYSLO)			.05487		.060						
			0030	E		RJP-PW-R1	1.00	REM RPL PAPRWRK SIGN OFF DOC			.01001		.011						
9000			DB	01	00			.01		LABOR STANDARD HISTORY	.000	.000	.000						0
			0010						08JAN85 2 YEAR REVIEW/NO TIME CHANGE										
			0900						N MONROE/MANEAA										

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR

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15053A C130 BRAKE 9550402

RCC MNPNA

4B1-2-133

OPER TECH S S W F PF A/R REV

SUB T K NR A FA SUPPORT OCC <
STEP D L K C DC ELEMENT FACT

OCC <
FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE HOURS

PFD
TIME

STD HOURS

DLY PCT C

KNPNA	S	E	DB	EA	2	J	89081	1.00	PERCENT ENGR	99.9	NDI BRAKE C130	.70	.70		
2000			DB	01	00			.00			PART NUMBER/NSN	.000	.000	.000	0
	0010								WCD ROUTED PARTS REQUIRING FPI						
	0020								9550008	1630009972090					
	0030								9550069	1630000554747					
2001			DB	01	11			1.00			FPI 1ST TIME	.263	.029	.293	.8 41
	0030	E						2.00	ZLG-ND-Z2	ZYGLD INSP MED PART BLD 507		.13177		.292	
2050			DB	01	00			.00			PART NUMBER/NSN	.000	.000	.000	0
	0010								831109	1630003045430					
	0020								31301	1630003045430					
2051			DB	01	11			1.00			FMPI 1ST TIME	.263	.029	.292	41
	0020	E						1.00	ZLG-ND-M7	MAGNAGLO INSP MED. OBJECT		.20565		.228	
	0040	E						1.00	ZLG-ND-M2	MAGNETIZE WITH COIL		.01309		.014	
	0050	E						1.00	ZLG-ND-M3	MAGNETIZE WITH CONTACT POINT		.01501		.016	
	0060	E						1.00	ZLG-ND-M4	DEMAGNETIZE OBJECT AFTER INS		.01968		.021	
	0070	E						1.00	RJP-PW-R1	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
2057			DB	01	24			1.00			DEGREASE	.097	.023	.120	17
	0010	E						1.00	RWB-CV-D1	VAPOR CL (DEGR)HOOK/BASKET		.08709		.107	
	0020	E						1.00	RJP-PW-R1	REM RPL PAPRWRK SIGN OFF DOC		.01001		.012	
9000			DB	01	00			.00			LABOR STANDARD HISTORY	.000	.000	.000	0
	0010								08JAN85	2 YEAR REVIEW/NO TIME CHANGE					
	0900									N MONROE/MANEWA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRCP NR

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15053A C130 BRAKE 9550402

RCC MNPTN

481-2-133

OPER TECH S S W F PF A/R REV

SUB T K MR A FA SUPPORT OCC (

STEP	D L	K C	DC	ELEMENT	FACT
1				1.1	1.1
2				2.1	2.1
3				3.1	3.1
4				4.1	4.1
5				5.1	5.1
6				6.1	6.1
7				7.1	7.1
8				8.1	8.1
9				9.1	9.1
10				10.1	10.1
11				11.1	11.1
12				12.1	12.1
13				13.1	13.1
14				14.1	14.1
15				15.1	15.1
16				16.1	16.1
17				17.1	17.1
18				18.1	18.1
19				19.1	19.1
20				20.1	20.1
21				21.1	21.1
22				22.1	22.1
23				23.1	23.1
24				24.1	24.1
25				25.1	25.1
26				26.1	26.1
27				27.1	27.1
28				28.1	28.1
29				29.1	29.1
30				30.1	30.1
31				31.1	31.1
32				32.1	32.1
33				33.1	33.1
34				34.1	34.1
35				35.1	35.1
36				36.1	36.1
37				37.1	37.1
38				38.1	38.1
39				39.1	39.1
40				40.1	40.1
41				41.1	41.1
42				42.1	42.1
43				43.1	43.1
44				44.1	44.1
45				45.1	45.1
46				46.1	46.1
47				47.1	47.1
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52				52.1	52.1
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59				59.1	59.1
60				60.1	60.1
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63				63.1	63.1
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65				65.1	65.1
66				66.1	66.1
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69				69.1	69.1
70				70.1	70.1
71				71.1	71.1
72				72.1	72.1
73				73.1	73.1
74				74.1	74.1
75				75.1	75.1
76				76.1	76.1
77				77.1	77.1
78				78.1	78.1
79				79.1	79.1
80				80.1	80.1
81				81.1	81.1
82</					

OPC (----- DESCRIPTION -----)

STORED

SUPPLEMENTAL

BASE
HOLE...

PFD
TIME

STD
HOURS

A
 DIV PCT C

PN203	E	N	JA	EA	1	J	89090	1.00	PENDENT ENGR	.9	MACH. BRAKE HOUSING C-130	.66		.66	
0001			JA	01	00			.00			PART NUMBER/NSN	.000	.000	.000	0
0010									9550069		1630000556747				
0110			JA	01	00			.35			BORE PSTN CAVITIES	1.510	.000	.529	80
0010	N							1.00			BORE & TAP	1.35000		1.350	
0020	N							.05			SHARPEN TOOLS	3.00000		.150	
0030	E								RJP-PW-R1	1.00	REM RPL PAPRMWK SIGN OFF DOC	.01001		.010	
0120			JA	01	00			.25			LOCK PLATES	.535	.000	.134	20
0010	N							1.00			DRILL AND TAP HOLE	.52500		.525	
0020	E								RJP-PW-R1	1.00	REM RPL PAPRMWK SIGN OFF DOC	.01001		.010	
9000			JA	01	00			.00			LABOR STANDRD HISTORY	.000	.000	.000	0
0900											8 APR. 1988 RICHARD G. MARTIN MANEL-73357-MRPII				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRCP NR

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7NPM615053AM6203

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC NPM6

04/05/89
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A-E0468-HM1-DY-H45 PAGE 0001
87177

15053A C-130 BRAKE		RCC NPM6		04/05/89		A-E0468-HM1-DY-H45 PAGE 0001		87177	
OPER	TECH S S	M F PF A/R REV							
SUB	T K	MR A FA SUPPORT	OCC <	DESCRIPTION		BASE	PFD	STD	A
STEP D L	K C DC ELEMENT	FACT	STORED	SUPPLEMENTAL		HOURS	TIME	HOURS	DLY PCT C
M6203	E N JB EA 1	J 89081	.05 PERCENT ENGR .0	EDM HOUSING C130 BRAKE		.50		.02	
0001	JB 01 00		.00	PART NUMBER/NSN		.000	.000	.000	0
0010			9550069	1630000556747					
0011	JB 01 00		1.00	EDM BROKEN SCREW & TAPS		.500	.000	.500	100
0010 N			1.00	EDM BROKEN SCREW OR TAPS		.50000		.500	
9000	JB 01 00		.00	LABOR STANDARD HISTORY		.000	.000	.000	0
0010				OBJANGS 2 YEAR REVIEW/NO TIME CHANGE					
0900				N MONROE/MAHEAA					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRDP NR
<---X---X--->
1234567890123456 ELSE PUT IN END

ST-STEEL
 AL-ALUMINUM
 MS-MILD STEEL
 TTA-TITANIUM
 SS-S STL
 SM-SYNTHETIC
 L-LEAD

190539
BILL OF MATERIALS
C130 NLO DRIVE ASSY

ROUTED	ITEM	UOM	LEVEL	PART NUMBER	VENDOR CODE	STOCK NUMBER	DESCRIPTION	UNITS	UNIT PRICE	YIELD	SCRAP	PART NAME	REV	EFFECTIVITY	TECH	DWG	NUMBER	ACTION	PENDING	ZZZ	ACTION	PENDING
	ISRL		1.1	1511597		173942	1..ADAPTER, INLET	11	IEA													
			1.1	11604-78		17945	1..PLUG, BENTAL	11	IEA													
			1.1	1162070-6		1533000045475	1..PULVER	11	IEA													
			1.1	116209-1007F		15330000378413	1..SCREEN, W/LDIX	14	IEA													
	ISRL		1.1	17027185-01		1163000494544	1..PLATE, LOCKING	12	IEA													
			1.2	116124623		15340000973210	1..HELICOID, BOLT HOLE	12	ARIEA													
			1.2	116124624		15340000973211	1..HELICOID, BOLT HOLE	13	ARIEA													
			1.2	116124735		153400002700480	1..HELICOID, PLATE HOLE	14	ARIEA													
			1.2	116124736		11630000072235	1..WASHER, BRACE	11	IEA													
			1.1	11620427-5210		153300000710975	1..KIT, FIELD	11	IEA													
			1.2	11620427-5210		153300000710975	1..RIVET	14	IEA													
			1.2	11620427-5210		153300000710975	1..BUTTON, SWAP FASTER	14	IEA													
			1.2	11620427-5210		153300000710975	1..LIMING, BRACE, RESIDENT	14	IEA													
			1.2	11620427-5210		153300000710975	1..LIMING, BRACE, PISTON	14	IEA													
			1.2	11620427-5210		153300000710975	1..WASHER	11	IEA													
			1.2	11620427-5210		173942	1..NUT, ADJUSTING PIN	14	IEA													
			1.2	11620427-5210		173942	1..SPACER, ADJUSTING PIN	14	IEA													
			1.2	11620427-5210		173942	1..BRIP, ADJUSTING PIN	14	IEA													
			1.2	11620427-5210		173942	1..ADAPTER, SEAL	14	IEA													
			1.2	11620427-5210		180044	1..SCREEN, BLEEDER	12	IEA													
			1.2	11620427-5210		180044	1..SCREEN, BLEEDER	12	IEA													
			1.2	11620427-5210		180044	1..WASHER	14	IEA													
			1.2	11620427-5210		180044	1..BOLT	12	IEA													
			1.2	11620427-5210		180044	1..SCREEN	14	IEA													
			1.2	11620427-5210		173942	1..WASHER	14	IEA													
			1.2	11620427-5210		173942	1..BOLT	12	IEA													
			1.2	11620427-5210		173942	1..SCREEN	14	IEA													
			1.2	11604-78		179355	1..PLUG, BENTAL	11	IEA													

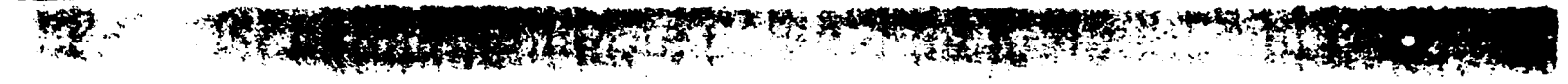
1/0 MANIP
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0.5 350Y
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for

File: 1821DN, Wks 3
Rotor

NAME: PONI 15053A		ALC: UU		KUC: BRAKES				WCU: 1821UN		WCU DATE: 18Y08/					
UP #	KUC	UP DESC	UP FAC	UP UCU	UP TYPE	UP MAND	FLUM HRS	SKIL CODE	QTY %	TIME %	REU HRS	EDUIP CODE	QTY %	TIME %	REU HRS
U05	MANIPUM	DIS	1.00	P				MBUS	1	100	0.02	WB0001	1	100	0.02
U05B	MANIPUM	STACK	1.00	P				MBUS	1	100	0.02				
U05C	MANIPUM	LOAD	1.00	P				MBUS	1	100	0.08	PM/432	1	50	0.08
U08	MANIPUM	CLN	1.00	S				MBUS	1	100	0.01				
U08A	MANIPUM	CLN	1.00	P		100	0.08					PM/432	1	100	0.08
U08B	MANIPUM	UNLD	1.00	P				MBUS	1	100	0.08	PM/432	1	50	0.08
U08C	MANIPUM	MOVE	1.00	I				UWHD	1	100	0.08	FLU0003	1	100	0.08
U14	MANIPUM	MAG	1.00	I				UWHD	1		0.02	FLU0001	1		0.02
U14	MANIPUM	MAG	1.00	P				UBUY	1		0.10	PM6668	1		0.10
U17	MANIPUM	DEUK	1.00	P				UBUY	1		0.07	PM3428	1		0.07
U20	MANIPUM	INSP	1.00	P				U107	1	100	0.25	PP0001	1	100	0.25
U20A	MANIPUM	STACK	1.00	P				U107	1	100	0.02				
U30	MANIPUM	SKIN	1.00	I				JAUJ	1		0.02				
U30	MANIPUM	SKIN	1.00	S				JAUJ	1		0.15	PM6652	1		0.15
U30	MANIPUM	SKIN	1.00	P				JAUJ	1		0.20	PM6652	1		0.20
U40	MANIPUM	MAG	1.00	I				UWHD	1		0.02	FLU0002	1		0.02
U40	MANIPUM	MAG	1.00	P				UBUY	1		0.10	PM6668	1		0.10
U50	MANIPUM	DEUK	1.00	P				UBUY	1		0.07	PM3428	1		0.07

File names: 18213, wknd
Plate Subassy.

[illegible]

Filename: 18203N, Wk4
Housing

215-224

11/28/2011 11:00 AM

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— 25 —

Pyramid
Filename: 18203N, Wk1

[illegible]

10000
ake

File number 18214N, Wed
Brake Assy.

NAME:		ALC: UU		KCU: BRAKES		WLD: 18214N		WLD DATE: 8Y004				
PLN: 15053A												
UP	#	KCU	UP	UCCU	UP	MAND	FLW	SKIL	TIME	REV	TIME	REV
			DESC	PAC	TYPE	%	HRS	CODE	QTY	%	QTY	%
UUU	MANPUP		IND	1.00	P			HB07	1	100	0.10	0.10
UU1	MANPUP		IND	1.00	P			HB05	1	100	0.03	
UU5	MANPUP		SPL11	1.00	S			HB05	1	100	0.08	0.05
UU5	MANPUP		SPL11	1.00	P			HB07	1	70	0.10	0.05
UU5	MANPUP		SPL11	1.00	P			HB07	1	30	0.25	0.30
UU10	MANPUP		MICH	1.00	P			UVM0	1	100	0.50	
UU20	MANPUP		ASSY	1.00	P			YG0Y	1	1.45	0.05	1.45
UU30	MANPUP		IES1	1.00	P			YG0Y	1	0.17	0.17	0.17
UU30	MANPUP		IES1	1.00	P			YG0Y	1	0.17	0.17	0.17
UU40	MANPUP		DELAL	1.00	P			YG0Y	1	0.05	0.05	0.05
UU50	MANPUP		ALP1	1.00	P			YG0Y	1	0.05	0.05	0.05
UU60	MANPUP		INSP	1.00	P			YG0Y	1	0.02	0.02	0.02

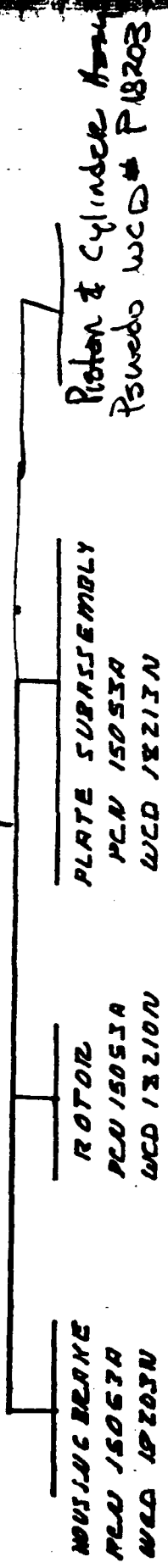
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FILE NAME: P18203, Wkd

NAME:		ALU: UU		RUC: BRakes		WLD: P18203		WLDUATE: 87200	
PUN: 100534									
UP	RUC	UP	UCCU	UP	MANO	FLW	SKIL	TIME	REV
#		DESC	PAC	TYPE	%	HRS	CODE	QTY	%
U10A	MANIPUP	DIS	1.00	I			YGUY	1	0.03
U10A	MANIPUP	DIS	1.00	P			YGUY	1	0.03
U20	MANIPUP	CLN	1.00	I			YGUY	1	0.03
U20	MANIPUP	CLN	1.00	P			YGUY	1	0.04
U20	MANIPUP	CLN	1.00	P			YGUY	1	0.04
U20	MANIPUP	CLN	1.00	P			YGUY	1	0.04
U30	MANIPUP	INSR	1.00	P			YGUY	1	0.05
U40	MANIPUP	ASSY	1.00	P			YGUY	1	0.10

C 130
BRAKE
ASSY

C 130 BRAKE ASSY
PCN 15053A
WCD 18214N



(G402A-TIP001)

LABOR STD REVIEW 14, APR, 89

7:58 AM

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	HOURS
		00010	E	YG	5	1.34	1.00	1.34
		PM214	N	YG	5	.58	1.00	.58
		FP203	N	3S	5	.33	1.00	.33
		PP213	E	3S	5	.08	1.00	.08
		PS203	E	YG	5	.02	1.00	.02
		PS210	E	YG	5	.02	1.00	.02
		PS213	E	YG	5	.02	1.00	.02
		PT214	N	YG	5	.41	1.00	.41
								2.80
		WC001	E	KI	5	.59	1.00	.59
		WD001	E	HB	5	.99	1.00	.99
		WE203	N	DI	5	.36	1.00	.36
		WE210	E	DI	5	.39	1.00	.39
		WE213	N	DI	5	.25	1.00	.25
								2.58
		MG203	N	JB	1	.50	.05	.2
								2
		MN203	N	JA	1	.66	1.00	.66
								66
		NA210	E	DB	2	.28	1.00	.28

7:58 AM

PROD NBR	RCC	OPER NBR	TYP STD	SK	FAC	STAND HOURS	OCC FAC	STAN HOURS
5053	MNPN A	NA213	E	DB	2	.07	.05	
		XNPN A	X	DB	2	.71	1.00	71
	*							99
	MNPN A	RA203	E	JA	1	1.13	1.00	1.13
		RA213	N	JA	1	.78	.05	3
	*							1.16
	MNPN B	RB210	E	JA	1	1.74	.75	1.30
	*							1.30
	MNPN C	RC203	E	UP	B	.19	1.00	19
		RC213	E	UP	B	.54	1.00	54
	*							73
	MNPN W	WW203	N	WL	B	3.21	.10	32
	*							32

CONTROL NUMBER LIST

PLAN	CONTROL	JOP	AIRCRAFT	DESCRIPTION	STOCK NUMBER	PART NUMBER	TECHORDER	8019 FLOW DAYS
TECH	TECH	NUMBER	DESC					
PARK	ANDE	14084A	-6	LGM 30	T.E. ACTUATOR	1450-00-089-6952AH	25-62100-1	3503-11-25-13 14
MART	SHEL	14443A		F-4	TIME RELEASE MECH	1680-00-702-9382LS	MBEU1161045	13A5-37-3 4
MART	SHEL	14557A		F-4	FUEL PYLON ASSY	1560-00-910-9099BF	26-370-4715	6J14-2-18-3 10
MART	SHEL	14703A		F-4	DROGUE GUN	1377-00-483-9072	MBEU34203	13A5-37-3 2
MART	SHEL	14813A		F-4	I.B. L/H LAU 17 PYLON	1560-00-489-6617BF	32694581-121	16W6-1-103 25
MART	SHEL	14814A		F-4	I.B. R/H LAU 17 PYLON	1560-00-489-6619BF	32694581-122	16W6-1-102 25
JENS	COOP	14991A		F-111 MLG	STABILIZER ROD	3040-00-164-6783	12L9530-003	4A4-15-3 12
MART	SHEL	14996A		F-4	EDN ADAPTER	1560-00-350-7820BF	536970150-301	16W16-7-3 14
JENS	PRIC	15025A	-6-J	F-106 MLG	WHEEL	1630-00-782-0521	63J32425-5	4W1-7-1173 21
JENS	RIGB	15053A	-6-J	C-130 MLG	BRAKE ASSY	1630-00-852-0403	9500000	4B1-2-113 2
JENS	RIGB	15054A	-6-J	KC-135 MLG	BRAKE ASSY	M 1630-00-858-5242	2600300-2	4B1-4-263 28
JENS	RIGB	15068A	-6-J	B-52 MLG	BRAKE ASSY	M 1630-00-077-6698	149016-9	4B1-4-133 28
JENS	RIGB	15107A	-6-J	F-106 MLG	BRAKE ASSY	1630-00-658-0638	151806-1	4B1-4-223 30
JENS	PRIC	15139A	-6-J	B-52 MLG	WHEEL	M 1630-00-900-9739	3-1192	4W1-7-1143 21
JENS	PRIC	15143A	-6-J	KC-135 MLG	WHEEL	1630-00-689-6014	211A243M2	4W3-7-113 30
JENS	RIGB	15161A	-6-J	C-141 MLG	BRAKE ASSY	M 1630-00-881-0015	9560738	4B1-2-373 26
JENS	RIGB	15162A	-6-J	KC-135 MLG	BRAKE ASSY	M 1630-00-269-2622	149499-4	4B1-4-263 28
JENS	RIGB	15222A	-6-J	F-4C MLG	BRAKE HOUSING SUB ASSY.	1630-00-927-1825	10 OCT 80	4B1-2-1093 23
JENS	RIGB	15229A	-6-J	T-33 MLG	BRAKE ASSY	1630-00-315-4832	9540726	4B1-2-293 24
JENS	PRIC	15248A	-6-J	F-100 MLG	WHEEL	1630-00-900-0745	63J32425-9	4W1-7-1173 20
JENS	PRIC	15279A	-J	F-5 MLG	WHEEL	1630-00-050-9531	219A43	4W1-0-33 30
JENS	RIGB	15295A	-6-J	F-111 MLG	BRAKE ASSY	M 1630-00-002-7955	2-966-9	4B1-2-483 32
JENS	PRIC	15302A	-J	F-111 MLG	WHEEL	1630-00-941-4191	2600335	4W3-7-1123 20
JENS	RIGB	15327A	-6-J	C-130 MLG	BRAKE ASSY	1630-00-825-4794	9560685	4B1-2-1003 27
JENS	RIGB	15335A	-J	C-141 MLG	BRAKE TAIL TUBE	1630-00-567-0169	9550025	4B1-2-373 16
JENS	PRIC	15348A	-6-J	F-111 MLG	WHEEL	1630-00-043-0965	3-1160-1	4W3-7-1283 20
JENS	PRIC	15351A	-6-J	B-52 MLG	WHEEL	1630-00-967-6779	3-1133	4W1-7-1143 20
JENS	PRIC	15359A	-6-J	KC-135 MLG	WHEEL	1630-00-013-9129	153245-4	4W1-7-263 20
JENS	PRIC	15361A	-6-J	B-52 MLG	WHEEL	1630-00-054-2557	2600293-1	4W1-7-1193 30
JENS	RIGB	15387A	-6-J	T38 MLG	BRAKE ASSY	1630-00-555-7523	2-727-3	4B1-2-173 27
RIGB	RIGB	15438A	-J	C-131 MLG	BRAKE ASSY	1630-00-580-2857	9541104	4B1-2-423 10
RIGB	RIGB	15460A	-6-J	KC-135 MLG	WHEEL	M 1630-00-492-7144	153245-5	4W1-7-263 20
DELE		15470A	-J	C-7A MLG	WHEEL	1630-00-125-7194	17 OCT 80	4W1-4-1023 20
JENS	RIGB	15481A	-6-J	C-141 MLG	WHEEL	1630-00-453-4893	5000169	4W1-7-1123 20
JENS	PRIC	15485A	-6-J	F-4 MLG	WHEEL	1630-00-446-3778	5000504	4W1-0-53 20
JENS	RIGB	15490A	-J	F-106 MLG	BRAKE BACKING PLATE	1630-00-671-2840	151007	4B1-4-223 16
JENS	PRIC	15510A	-J	T-33 MLG	WHEEL	1630-00-406-3998	5000563	4W1-7-1313 20
JENS	RIGB	15519A	-6-J	FB-111 MLG	BRAKE STATOR PLATE	1630-00-113-2133	9536123	4B-2-493 14
JENS	RIGB	15521A	-J	FB-111 MLG	BRAKE PRESSURE PLATE	1630-00-056-2073	9533542	4B1-2-493 19
JENS	PRIC	15523A	-6-J	F-111 MLG	WHEEL	1630-00-157-6723	3-1156-0	4W1-7-1263 21
JENS	PRIC	15526A	-6-J	B-52 MLG	WHEEL	1630-00-242-0942	2600773	4W1-7-1193 30
JENS	RIGB	15531A	-J	F-106 MLG	BRAKE STATOR PLATE	1630-00-671-2839	151005	4B1-4-223 16
JENS	RIGB	15536A	-J	F-111 MLG	BRAKE BACKING PLATE	1630-00-057-0991	329-15	4B1-2-483 19
JENS	PRIC	15575A	-J	F-5 MLG	WHEEL	1630-00-139-0476	5001114-3	4W1-0-63 20
JENS	RIGB	15576A	-J	F-5 MLG	BRAKE ASSY	1630-00-147-3854	5001111-1	4B1-2-1113 20
JENS	RIGB	15583A	-J	FB-111 MLG	BRAKE ASSY	1630-00-032-9000	9560006	4B1-2-493 23

18203N

WORK CONTROL DOCUMENT (MEDS)

89087

PAGE 1 OF 1 PAGES

2. JOB ORDER NO. 15053A		3. QUANTITY		4. PRODUCTION SEC/RCC MNPGR		5. DATE SCHED 8294		6. DATE COMPLETED	
7. PART NUMBER 9550069			8. TECH DATA 4B-1-32 4B1-2-133				9. ITEM SERIAL NO.		
10. MODEL-DESIGN-SERIES C-130 BRAKE			11. STOCK NUMBER 1630000556747			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN HOUSING BRAKE C-130			15053A			
15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		***** UNIT COST: \$3529.00 ***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FPI IAW MIL-STD-6866 ANODIZE IAW MIL-A-8625 *****ALUMINUM*****							
		ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.							
		WARNING MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.							
		REQD (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.							
	001	9550069							
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		18203N			
		B		D					

18203N

WORK CONTROL DOCUMENT (MEDS)

DATE 89087

3

PAGE 3 OF 3 PAGES

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED 8294	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN HOUSING BRAKE C-130	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		AS MARKED *C/P MOVE*		001 MNPWW 002 04 003 WT03	
69	060 .01	MACHINE CAVITY NOT TO EXCEED 3.376 *C/P MOVE*		001 MNPRA 002 01 003 MV01	
69	070 .01	DRILL AND TAP INLET PORT *C/P MOVE*		001 MNPRA 002 01 003 DR01	
69	080 .01	DRILL AND TAP BLEEDER PORT *C/P MOVE*		001 MNPRA 002 01 003 DR01	
69	090 .01	ASSEMBLY BOLT HOLE REPAIR I.A.W. T.O. PAGE 8, PARA 0 *C/P MOVE*		001 MNPRA 002 01 003 DR01	
69	100 .18	PISTON PIN SEAL AREA I.A.W. T.O. PAGE 5 FIGURE 4 *C/P MOVE*		001 MNPRA 002 01 003 DR01	
67	110 .01	MACHINE PISTON CAVITIES I.A.W. T.O. PAGE 4, FIGURE 3 *C/P MOVE*		001 MNPMM 002 02 003 MH30	
67	120 .20	DRILL AND TAP - LOCK PLATE I.A.W. T.O. PAGE 8, PARA P *C/P MOVE*		001 MNPMM 002 02 003 MH30	
26	130 *REQD*	ANDRIZE TYPE II CLASS I *C/P MOVE*		001 MNPRC 002 03 003 AS03	
69	140 *REQD*	*C/P MOVE*		001 MNPRA 002 01 003 BE01	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	18203N
		B	D	

2. JOB ORDER NO.	3. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED 8294	6. DATE COMPLETED
7. PART NUMBER		8. TECH DATA		9. ITEM SERIAL NO.

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13. SERIAL NUMBER	14 NOUN HOUSING BRAKE C-130	

18. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. P	20. Q
69	150	INSTALL HELICOILS I.A.M. 150. PAGE 8, PARA 8A *C/P MOVE*		001 MNPRA 002 01 003 BE01	
		P/N MS124823 P/N MS124824 P/N MS124735			
	160	PRE-FINAL INSPECTION *C/P MOVE*		001 MNP GP 002 08 003 PF01	
	REQD				
	170	MASK, PRIME AND PAINT *C/P MOVE*		001 MNP GP 002 09 003 BS02	
	REQD				
	180	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958		001 MNP GP 002 08 003 MU08	
	REQD				
	190	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE		001 MNP GP 002 08 003 MU08	
	REQD				

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	18203N
		B	D	

18210N WORK CONTROL DOCUMENT (MEDS)

DATE 89087

PAGE 1 OF 1 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC MNP GW		5. DATE SCHED		6. DATE COMPLETED					
7. PART NUMBER				8. TECH DATA 4B-1-32 4B1-2-133				9. ITEM SERIAL NO.					
10. MODEL-DESIGN-SERIES C-130 BRAKE			11. STOCK NUMBER			12. OPTIONAL							
13. SERIAL NUMBER			14. NOUN ROTOR			15053A							
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED				18. MECHANIC		19. "P"		20. "Q"	
P/N 9531109 31301				NSN C/N 1630003045430 15053A 1630003045430									
				*****UNIT COST \$ 231.60***** GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FMPI IAW MIL-STD-1949 P/O N01561 *****S T E E L*****									
				ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT. *COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS. *****"W A R N I N G"***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES. *REQD* (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP									
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN									
DISPATCH		FUNCTIONAL CODE		A				C				18210N	
				B				D					

18210N WORK CONTROL DOCUMENT (MEDS)

1. DATE 89087

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN ROTOR						
15. DISPATCH STATION		16. PERF RCC/OP NO.		17. WORK TO BE ACCOMPLISHED		18. MECHANIC		20. "P" "Q"	
		001		9531109 31301					
		[REDACTED]		DISASSEMBLE *C/P MOVE*				001 MNPBW 002 02 003 BD04	
		REQD							
		[REDACTED]		ROTO BLAST CLEAN *C/P MOVE*				001 MNPBW 002 03 003 RB07	
		REQD							
		[REDACTED]		*C/P MOVE*		M		001 MNPNA 002 05 003 MS03	
		REQD							
		[REDACTED]		*C/P MOVE*				001 MNPNA 002 05 003 DG01	
		REQD							
		[REDACTED]		E & I DISK THICKNESS 0.925/1.056 KEY SLOT WIDTH 0.938 MAX				001 MNPBW 002 04 003 EI02	
		REQD							
BX		030		GRIND NOT TO EXCEED 0.925 80 R.M.S. *C/P MOVE*				001 MNPBR 002 03 003 GR01	
		[REDACTED]		*C/P MOVE*		M		001 MNPNA 002 05 003 MS03	
		REQD							
		[REDACTED]		*C/P MOVE*				001 MNPNA 002 05 003 DG01	
		REQD							
		060		PRE-FINAL INSPECTION *C/P MOVE*				001 MNPBP 002 08 003 PF01	
		REQD							

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN	
DISPATCH	FUNCTIONAL CODE	A	C	18210N	
		B	D		

18213N

WORK CONTROL DOCUMENT (MEDS)

1 DATE 89041

PAGE 1 OF 1 PAGES

2. JOB ORDER NO. 15053A	3. QUANTITY	4. PRODUCTION SEC/RCC MNP GW	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER 9550008	8. TECH DATA 4B-1-32 4B1-2-133		9. ITEM SERIAL NO.	

10. MODEL-DESIGN-SERIES C-130 BRAKE	11. STOCK NUMBER 1630009972090	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN PLATE SUBASSEMBLY	15053A

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
		GOVERNING DIRECTIVES: AFLCR 66-51 MANOI 66-3 FPI IAW MIL-I-6866 SHOT PEEN IAW MIL-S-13165 ANODIZE IAW MIL-A-8625			
		*****ALUMINUM***** ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.			
		*COMPONENTS WILL BE THOROUGHLY CLEANED AND PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.			
		*****"W A R N I N G"***** MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES, & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.			
		REQD (MANDATORY REQUIREMENT) IN BLOCK 16 SERVES THE SAME PURPOSE AS DELTA STAMP			
	001	9550008			
		DISASSEMBLE	*C/P MOVE*	001 MNP GW	
		REQD		002 02	
				003 BD04	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/SN
DISPATCH	FUNCTIONAL CODE	A	C	18213N
290				

18213N

WORK CONTROL DOCUMENT (MEDS)

89041

PAGE 2 OF 2 PAGES

2. JOB ORDER NO.		3. QUANTITY		4. PRODUCTION SEC/RCC		5. DATE SCHED		6. DATE COMPLETED	
7. PART NUMBER				8. TECH DATA				9. ITEM SERIAL NO.	
10. MODEL-DESIGN-SERIES			11. STOCK NUMBER			12. OPTIONAL			
13. SERIAL NUMBER			14. NOUN PLATE SUBASSEMBLY						
15. DISPATCH STATION	16. PERF RCC/OP NO.	17. WORK TO BE ACCOMPLISHED				18. MECHANIC	19. "P"	20. "Q"	
		CHEM CLEAN *C/P MOVE*					001 MNP GW		
	REQD						002 03		
							003 AC02		
		ELAST CLEAN *C/P MOVE*					001 MNP GW		
	REQD						002 03		
							003 BL01		
		ANODIZE STRIP *C/P MOVE*					001 MNP GW		
	REQD						002 03		
							003 AN03		
		C/P MOVE				M	001 MNP NA		
	REQD						002 05		
							003 ZY05		
		NICK & BURR *C/P MOVE*					001 MNP GW		
	REQD						002 04		
							003 NB04		
		E&I ALIGNMENT HOLE MAX 0.550 *C/P MOVE*					001 MNP GW		
	REQD						002 04		
							003 EI02		
69	030	MACHINE THE 0.240 INCH RADIUS, TO REMOVE FATIGUE CRACKS BUT NOT TO EXCEED 0.030 INCH IN DEPTH. I.A.W. T.O. 4B1-2-133, PAGE 5, PARA 1 & FIGURE 6. *C/P MOVE*					001 MNP RA		
							002 01		
							003 LE05		
69	040	ALIGNMENT HOLE REPAIR I.A.W. T.O. 4B1-2-133, PAGE 6, PARA 4 & FIGURE 6. *C/P MOVE*					001 MNP RA		
							002 01		
							003 DR02		
		C/P MOVE				M	001 MNP NA		
							002 06		
							003 ZA02		
21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE				23. DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A		C		18213N			
		B		D					

18213N

WORK CONTROL DOCUMENT (MEDS)

DATE

890488

PAGE 07 PAGES

1. JOB ORDER NO.	2. QUANTITY	4. PRODUCTION SEC/RCC	5. DATE SCHED	6. DATE COMPLETED
7. PART NUMBER	8. TECH DATA			9. ITEM SERIAL NO.

3. MODEL-DESIGN-SERIES	11. STOCK NUMBER	12. OPTIONAL
13. SERIAL NUMBER	14. NOUN PLATE SUBASSEMBLY	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. "P"	20. "Q"
26	060	SHOT PEEN REWORKED AREA 0.010 TO 0.012 A/2 INTENSITY USING NO. 230 STEEL SHOT *C/P MOVE*		001 MNPRC 002 01 003 SP01	
26	070	ANODIZE TYPE II *C/P MOVE*		001 MNPRC 002 03 003 AS03	
69	080	INSTALL ALIGNMENT HOLE BUSHING I.A.W. T.O. FIGURE 6. *C/P MOVE* P/N 66C33001-109A		001 MNPRC 002 01 003 BE01	
	090	PRE-FINAL INSPECTION *C/P MOVE*		001 MNPRC 002 08 003 PF01	
	100	PRIME *C/P MOVE*		001 MNPRC 002 09 003 BS02	
	110	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS SEC		001 MNPRC 002 08 003 MU08	
	120	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE*		001 MNPRC 002 08 003 MU08	

21. FINAL DESTINATION		22. COORDINATION/INITIATING RCC SIGNATURE/DATE		23. DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	18213N
		B	D	

1E203N WORK CONTROL DOCUMENT (MEDS)

1 DATE

E7217

PAGE 1 OF 1 PAGES

2 JOB ORDER NO 15023A		3 QUANTITY 91A		4 PRODUCTION SEC/RCC MANPGW		5 DATE SCHED 19 OCT 1998		6 DATE COMPLETED	
7 PART NUMBER 9550402		8 TECH DATA 4B-1-32 4P1-2-133		9 ITEM SERIAL NO MAY 67-806					
10 MODEL DESIGN SERIES C-130 BRAKE		11 STOCK NUMBER 163000052E403		12 OPTIONAL WIP					
13 SERIAL NUMBER E15209		14 NOUN BRAKE C130		15 3ea - 90743103-84A					
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19	20	
		<p>***** UNIT COST: \$3529.00 *****</p> <p>GOVERNING DIRECTIVES: AFICK 66-51</p> <p>MANOI 66-3</p> <p>FPI IAW MIL-STD-6666</p> <p>ANODIZE IAW MIL-A-6625</p> <p>*****ALUMINUM*****</p> <p>ALL PERSONNEL INVOLVED IN THE WORK PROCESSES SPECIFIED IN THIS DOCUMENT HAVE BEEN THOROUGHLY TRAINED AND ARE FAMILIAR WITH ALL PERTINENT SAFETY PRACTICES AND HAZARDS CONTAINED IN THE BASIC TECHNICAL ORDER (T.O.) AND T.O. SUPPLEMENTS REFERENCED. THE APPLICABLE T.O.'S AND SUPPLEMENTS WILL ALWAYS BE USED IN CONJUNCTION WITH THIS DOCUMENT.</p> <p>*COMPONENTS WILL BE THOROUGHLY CLEANED & PROTECTED (C/P MOVE) FOR MOVES BETWEEN OPERATIONS/DISPATCH STATIONS.</p> <p>WARNING</p> <p>MANY OF THE FOLLOWING REPAIR PROCEDURES REQUIRE THE USE OF EQUIPMENT, PROCESSES & CHEMICALS WHICH ARE POTENTIALLY DANGEROUS TO PERSONNEL. ADEQUATE SAFEGUARDS AND PRECAUTIONS MUST BE EMPLOYED TO PRECLUDE INJURIES.</p> <p>*REQD* (MANDATORY REQUIREMENT) IN COLUMN 16 IS EQUIVALENT TO DELTA STAMP.</p>							
34L	001	DISASSEMBLE							
	REQD	*C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A	C			1E203N			
		B	D						

1E2K3N WORK CONTROL DOCUMENT (MEDS)

1 DATE

67217

PAGE 2 OF 2 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN BRAKE C132						
15 DISPATCH STATION	16 PERF RCC/OP NO.	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19	20	
34C	003	CLEAN AS REQ'D *ELCI* *C/P MOVE 01 NOV 1988				70255	70288		
66	005	EDM BROKEN SCREWS & TAPS *C/P MOVE*							
34	010	FPI *C/P MOVE				02 NOV 1988 (70255)	(70255)		
34	020	NICK AND FURR *C/P MOVE 15 DEC 1988				71234	71204		
34	030	E AND I INSPECTION PISTON CAVITY MAX I.D. 3.386 *REQD* *C/P MOVE				DEC 15 1988 (71234)			
25	040	WELD CROSSOVER PORTS 100% *C/P MOVE				71234 JAN 1989			
25	050	WELD INLET PORT *C/P MOVE							
25	060	WELD BLEEDER PORTS AS MARKED *C/P MOVE							
69	065	PCLISH CAVITY NOT TO EXCEED 3.376 *C/P MOVE							
69	080	DRILL AND TAP INLET PORT *C/P MOVE							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/BN			
DISPATCH	FUNCTIONAL CODE	A				C			
		B				D			
						1E2K3N			

1E203N WORK CONTROL DOCUMENT (MEDS)

1 DATE

87217

PAGE 3 OF 3 PAGES

2 JOB ORDER NO	3 QUANTITY	4 PRODUCTION SEC/RCC	5 DATE SCHED	6 DATE COMPLETED
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7 PART NUMBER	8 TECH DATA	9 ITEM SERIAL NO
---------------	-------------	------------------

10 MODEL-DESIGN-SERIES	11 STOCK NUMBER	12 OPTIONAL
13 SERIAL NUMBER	14 NOUN BRAKE C130	

15. DISPATCH STATION	16. PERF RCC/OP NO	17. WORK TO BE ACCOMPLISHED	18. MECHANIC	19. P	20. Q
69	090	DRILL AND TAP BLEEDER PORT *C/P MOVE			
69	100	TIE BOLT HOLE REPAIR *C/P MOVE		M	
69	110	PISTON PIN SEAL AREA *C/P MOVE		M	
67	120	SLEEVE PISTON CAVITIES *C/P MOVE		M	
67	130	DRILL AND TAP - LOCK PLATE *C/P MOVE		M	
26	140 *REQD*	ANODIZE TYPE II CLASS I *C/P MOVE			
69	145 *REQD*	CHECK HELICOILS *C/P MOVE			
69	150 *REQD*	INSTALL HELICOILS *C/P MOVE			
13	160 *REQD*	OK TO ASSEMBLE *C/P MOVE			
13	170 *REQD*	MASK, PRIME AND PAINT *C/P MOVE			

70885

25 JAN 1989

70629

70629

26 JAN 1989

71164

71164

27 JAN 1989

70159

21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE		23 DOCUMENT/BN
DISPATCH	FUNCTIONAL CODE	A	C	1E203N
		B	D	

1E203N WORK CONTROL DOCUMENT (MEDS)

1 DATE

E7217

PAGE 4 OF 4 PAGES

2 JOB ORDER NO		3 QUANTITY		4 PRODUCTION SEC/RCC		5 DATE SCHED		6 DATE COMPLETED	
7 PART NUMBER				8 TECH DATA				9 ITEM SERIAL NO	
10 MODEL DESIGN SERIES			11 STOCK NUMBER			12 OPTIONAL			
13 SERIAL NUMBER			14 NOUN BRAKE C130						
15 DISPATCH STATION	16 PERF RCC/OP NO	17 WORK TO BE ACCOMPLISHED				18 MECHANIC	19	20	
13	180 *RECI*	SERVICEABLE PART ISSUE *C/P MOVE 3/14/89				71412			
13	190 *REQD*	ASSEMBLE *C/P MOVE 3/14/89				71412			
13	200 *REQD*	PRESSURE TEST *C/P MOVE				70817	70817		
13	220 *REQD*	DECALS *C/P MOVE				70817			
13	225 *REQD*	FINAL ACCEPTANCE OF WORK CONTROL DOCUMENT FOR COMPLETENESS & ACCURACY OF ALL PRECEDING OPERATIONS THIS 958				70817	70817		
13	240 *REQD*	FINAL PRODUCT VISUAL INSPECTION *C/P MOVE				70817	70817		
		COORDINATION BY: PLANNER: FRANK RIGBY WK MEASURE: DOUGLAS JENSEN SCHEDULER: LOYAL WIENS							
		PRODUCTION: ROGER MURRAY							
		QUALITY: MILO STONES							
21 FINAL DESTINATION		22 COORDINATION/INITIATING RCC SIGNATURE/DATE				23 DOCUMENT/SN			
DISPATCH	FUNCTIONAL CODE	A		C		1E203N			
		B		D					

OPERATION PROFILE

F-15 BRAKE ASSY

NAME D. DIVELOISS ALC 00 DATE 10 JUN 89 RCC MANPGW SHEET 1 OF 1

WCD 36203N WCD DATE 89040

68735A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
1	MAN PGW	IND	1.00	TRANSIT												
				SETUP												
				PROCESS												
5	MAN PGW	DIS	1.00	TRANSIT			H305	1							SEPERATE	
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

SEPERATE

UK

OPERATION PROFILE

F-15 A/B ISRAELI - HOUSING ASSY (ALUM)

NAME D. DIVELESS ALC 00 DATE 10 JUN 89 RCC MTAN PGW SHEET 1 OF 3

WCD 36204N WCD DATE 89069															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS		
					MANDATORY FLOW HOURS	QTY.	SKILL CODE/LEVEL	QTY.	EQUIPMENT CODE	QTY.	%	HRS.			
														%	HRS.
5	MTAN PGW	DIS	1.00	TRANSIT									REM PISTON ASSY		
				SETUP											
				PROCESS											
7A	MTAN PGW	LOAD	1.00	TRANSIT									ALT PM0430 B.H. CONV.		
				SETUP											
				PROCESS											
7	MTAN PGW	CLN	1.00	TRANSIT									CHEM LINE		
				SETUP											
				PROCESS											
7B	MTAN PGW	LINLO	1.00	TRANSIT									ALT. 0626 6634		
				SETUP											
				PROCESS											
9	MTAN PGW	CLN	1.00	TRANSIT									BIAS		
				SETUP											
				PROCESS											
				TRANSIT									ALT. PM0412		
				SETUP											
				PROCESS											

T.O. 431-2-1123

1.50-3111120

OPERATION PROFILE

F-15 A/G Brake - Housing Assy

NAME <u>D. DIVERBESS</u> ALC <u>OG</u> DATE <u>10 JUN 89</u> RCC <u>MTANPGW</u> SHEET <u>2 OF 3</u>		WCD <u>36204N</u> WCD DATE <u>890669</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %
12A	MAN PGN	LOAD	1.000	TRANSIT									TO O.H. Conv.
				SETUP									
				PROCESS									
12	MAN PGN	Proc	1.000	TRANSIT									Anodize Strip
				SETUP									
				PROCESS									
12B	MAN PGN	TRAN	1.000	TRANSIT									From Anodize Strip to FRT.
				SETUP									
				PROCESS									
19A	MAN PGN	UNLP	1.000	TRANSIT									From O.H. to roller Conv.
				SETUP									
				PROCESS									
19	MAN PGN	Proc	1.000	TRANSIT									Nick & Burn.
				SETUP									
				PROCESS									

OK

OPERATION PROFILE

F-15 A/B ISRAELI - Housing Assy

NAME D. DIVEGLISS ALC CC DATE 16 Jun 89 RCC RTIANPGW SHEET 3 OF 3

WCD 36204N WCD DATE 890629														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS %	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %		HRS.
198	MTAN PEN	LOAD	1.000	TRANSIT										TO BELT CONVEYOR
				SETUP										
				PROCESS		VIEW5	1	1000.02	0000003	1	1000.02			
200	MTAN PEN	INSP	1.000	TRANSIT										E&I
				SETUP										
				PROCESS		DIS07	1	200.60						
								800.70						
200A	MTAN PEN	STACK	1.000	TRANSIT										TO PALLET
				SETUP										
				PROCESS		DIS07	1	1000.02						
203	OVHD PEN	MOVE	1.000	TRANSIT		OVHD	1	1000.08	FL00003	1	1000.08			MOVE TO MACHINE SHOP
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

OPERATION PROFILE

FISA/B BRAKE - BACKING PLATE (STEEL)

NAME D. DIVELEISS ALC 00 DATE 10 JUN 89 RCC MANPGRW SHEET 1 OF 2

PCN 68735A WCD 36205N WCD DATE 89073

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS		SKILL CODE/LEVEL	QTY.	%	HRS	EQUIPMENT CODE	QTY.	%	HRS	
5	MAN PGW	DIS	1.00	TRANSIT												REM FOREIGN MATERIAL
				SETUP												
				PROCESS				H305	1	100	.02	W3000	1	100	.02	
5 ^A		STACK	1.00	TRANSIT												on Pallet
				SETUP												
				PROCESS				H305	1	100	.02					
8 ^A		LOAD	1.00	TRANSIT												near Hooks
				SETUP												
				PROCESS				H305	1	100	.01	PM7432	1	50	.01	
8		CLW	1.00	TRANSIT												KOTOBlast
				SETUP				H305	1	100	.01					
				PROCESS	100	.08						PM7432	1	100	.08	
8 ^B		UNLO		TRANSIT												Near Hooks to Pallets
				SETUP												
				PROCESS				H305	1	100	.01	PM7432	1	50	.01	

T.O. 461-2-1123

OK

OPERATION PROFILE F-15 A/B Brake - Backings Plate

NAME D. DUBOISS ALC QC DATE 10 JUN 85 RCC RTANPSW SHEET 2 OF 2

WCD 36205N															WCD DATE 89073														
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OPERATION PROFILE

F-15 A/B Brake (30136) - 5/5

NAME D. DUGLASS ALC 00 DATE 12 JUN 88 RCC MTANP6W SHEET 1 OF 2WCD 36208N WCD DATE 89040

68735A

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NSN
PM

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						Skill CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	
5	MTAN P6W	DIS	1.000	TRANSIT								Rem. Foreign Mater
				SETUP								
				PROCESS		H805	1	100 .01	W80001	1	100 .01	
5b	MTAN P6W	Stack	1.000	TRANSIT								on pallet
				SETUP								
				PROCESS		H805	1	100 .01	W80001	1	100 .01	
5c	DUHO P6W	MOVE	1.000	TRANSIT								MOVE TO BLAST AREA
				SETUP								
				PROCESS		DUHO	1	100 .01	FLO003	1	100 .01	
9	MTAN P6W	CLW	1.000	TRANSIT								BLAST CLEAR
				SETUP								
				PROCESS		KI05	1	100 .01	Pm 7201	1	100 .01	
9b	MTAN P6W	Stack	1.000	TRANSIT								ALL PM 04/8 on pallet
				SETUP								
				PROCESS		KI05	1	100 .01				

DR

OPERATION PROFILE

F-15 A/B GRAVE (120fts)

NAME D. DIVEGLISS ALC SS DATE 12 Jun 89 RCC MTANPGW SHEET 2 OF 2

WCD 36208N WCD DATE 83040																
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS					
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE		QTY.	TIME REQUIRED			
								%	MRS.				%	MRS.		
20A	MTAN PGW	UNLO	1.00	TRANSIT										UNLO FROM O.H. CONW.		
				SETUP												
				PROCESS												
20	MTAN PGW	INSP	1.00	TRANSIT										CHECK LENGTH		
				SETUP												
				PROCESS												
20B	MTAN PGW	STAKE	1.00	TRANSIT										on pallet		
				SETUP												
				PROCESS												
20C	OVHD PLW	MOVE	1.00	TRANSIT										MOVE TO HANDNESS TEST		
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

02

OPERATION PROFILE

F-15 A/B BRAKE TORQUE TUBE (T2)

NAME <u>D. D. WELLS</u> ALC <u>CS</u> DATE <u>12 JUN 89</u> RCC <u>MANDEW</u> SHEET <u>1</u> OF <u>3</u>															
WCD <u>36205N</u> WCD DATE <u>89040</u>															
68735A															
NSN PM															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED % HRS.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS		
5	MAN PGW	Dis	1.00	TRANSIT									REM. HEAT SHIELDS		
				SETUP											
				PROCESS											
5b	MAN PGW	Stack	1.00	TRANSIT									on pallet		
				SETUP											
				PROCESS											
9a	DUHD PGW	MOVE	1.00	TRANSIT									MOVE TO 8a Room		
				SETUP											
				PROCESS											
9b	MAN PGW	UNLD	1.00	TRANSIT									TO TABLE TO BASKET		
				SETUP											
				PROCESS											
9c	MAN PGW	DEGR		TRANSIT									DEGRASS NaO2		
				SETUP											
				PROCESS											

TO 415(-2-1)23

CHANGE-051

OK

OPERATION PROFILE F-15 A/B BRAKE (TORQUE JUNE) (T-1)

NAME D. DIVELESS ALC 00 DATE 12 Jun 89 RCC MANASSA SHEET 2 OF 3

WCD 36209 N WCD DATE 89090

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
9d	MAN REW	CLN	1.00	TRANSIT											WET BRIST (vapour horn)	
				SETUP												
				PROCESS	100	.16	H305	1	60	116	PM5657	1	100	.16		
9e	MAN REW	Rinse	1.00	TRANSIT											HOT WATER	
				SETUP												
				PROCESS	100	.02	H305	1	100	.02	PM5657	1	100	.02		
9f	MAN REW	Rinse	1.00	TRANSIT											Cold Rinse	
				SETUP												
				PROCESS	100	.02	H305	1	100	.02	PM5657	1	100	.02		
9g	MAN REW	Stack	1.00	TRANSIT											on pallet	
				SETUP												
				PROCESS												
9h	ONHC plyd	MOVE	1.00	TRANSIT											TO FPI	
				SETUP												
				PROCESS												

OPERATION PROFILE

F-15 A/B BRADS - Tongue Tugs

NAME D. DUESS ALC 00 DATE 12 Jun 85 RCC MTANPGW SHEET 3 OF 3

WCD 36209N WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
20	MTAN PGW	INSR	1.000	TRANSIT							E & I
				SETUP							
				PROCESS			40 .15 600 .50				
20A	MTAN PGW	STACK	1.000	TRANSIT							on Pallet
				SETUP							
				PROCESS							
20B	OVHO PGW	MOVE	1.000	TRANSIT							TU STA.30 (pre final inspect before featuring).
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

OPERATION PROFILE

F-15 A/B GRABER - HEART SHIELD

100 (95)

NAME D. DINEBESS ALC 00 DATE 12 JUN 89 RCC HTANPGL SHEET 1 OF 2

WCD 36224N WCD DATE 89065

68735A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	QTY.	EQUIPMENT CODE	%	HRS.	
5	MAN PGW	DIS	1.00	TRANSIT										REM. Foreign MATH.
				SETUP										
				PROCESS										
5b	MAN PGW	LOAD	1.00	TRANSIT										Or 4. Conveyor
				SETUP										
				PROCESS										
9	MAN PGW	CLEAN	1.00	TRANSIT										ON STEEL CLEAN LINE
				SETUP										
				PROCESS										
9b	MAN PGW	TRAN	1.00	TRANSIT										TO FFI LINE (AUTOMATIC)
				SETUP										
				PROCESS										
20a	MAN PGW	UNLO	1.00	TRANSIT										From O.H. to Roller Conveyor
				SETUP										
				PROCESS										

1.50-21W12C

OPERATION PROFILE

F-15 A/B Brake - HEAT STACK ASSY

NAME D. DIVELEISS ALC 00 DATE 12 Jun 89 RCC MANDEW SHEET 1 OF 1

WCD 36236 WCD DATE 89061

68735

NON PM

68735																
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
					%	HRS.		SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.
5	MAN R6W	MANU	1.00	TRANSIT											MANU Alignment of HEAT STACK	
				SETUP												
				PROCESS												
5A	MAN R6W	STACK	1.00	TRANSIT											on pallet	
				SETUP												
				PROCESS												
10	O/HO R6W	MOVE	1.00	TRANSIT											TO (13) CARSON SHOP	
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

DR

OPERATION PROFILE

NAME <u>HERSTALAN</u> ALC _____ DATE _____ RCC _____ <u>Brakes</u> SHEET <u>1</u> OF _____												
WCD <u>36203N</u> WCD DATE <u>87040</u>												
WCD <u>68735A</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
010	MAN REP	match	1.0	TRANSIT								MATCH-UP
030		ARM	1.0	TRANSIT								Assembly
				SETUP								
				PROCESS								
040		Test	1.0	TRANSIT								Test
				SETUP								
				PROCESS								
050		Top		TRANSIT								Final Top paper work Details
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

F-15 Brake Assy

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

WCD 36204A WCD DATE 89069

68735A

68133A		MANPOWER										EQUIPMENT		DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.			%	HRS.	
15	MAN PNA	FPI	.75	TRANSIT							PM 0901	1		.02	
				PROCESS						PM 0901	1		1.05		
				PROCESS			2	DB09		.05	PM 0679E	1		1.05	
15A	MAN PNA	FPI	.25	TRANSIT							PM 0901	1		.02	
				PROCESS						PM 0901	1		1.10		
				PROCESS			1	DB09		.10	PM 0679E	1		1.10	
16	MAN PGW	UNLD	1.0	TRANSIT							PM 0901	1		.05	
				PROCESS						PM 0901	1		.05		
				PROCESS			1	KI07		.05	PM 0901	1		.05	
17	MAN PNA	COND	1.0	TRANSIT											
				PROCESS			1	DN10		.10	PM 0960	1		.10	
				PROCESS											
18	MAN PNA	HARD	1.0	TRANSIT											
				PROCESS			1	DN10		.10	PM 0960	1		.10	
				PROCESS											

F-15 Brake

OPERATION PROFILE

NAME <u>Turner</u> ALC <u>00</u> DATE <u>5-24-89</u> RCC <u>MANPRA</u> SHEET <u>1</u> OF <u>1</u>										
PCN NSN PM	WCD <u>36204 N</u> WCD DATE <u>89069</u>									
68735A										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER	EQUIPMENT	DATA SOURCE COMMENTS		
						SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
30	MAN			TRANSIT		JA 10	1		.02	
	PRA	Mach	1.00	SETUP		JA 10	1		.51	PM 4138
				PROCESS		JA 10	1		.64	PM 4138
40	MAN			TRANSIT		JA 08	1		.02	
	PRA	ReID	1.00	SETUP		JA 08	1		.28	PM 4138
				PROCESS		JA 08	1		.10	PM 4138
50	MAN			TRANSIT		JA 10	1		.02	
	PRA	Remo	1.00	SETUP		JA 10	1		.02	PM 4138
				PROCESS		JA 10	1		.03	PM 4138
70	MAN			TRANSIT		JA 08	1		.02	
	PRA	Remo	1.00	SETUP		JA 08	1		.28	PM 4138
				PROCESS		JA 08	1		.31	PM 4138
100A	MAN			TRANSIT		JA 09	1		.02	
	PRA	Repl.	1.00	SETUP		JA 09	1		.31	PM 4138
				PROCESS		JA 09	1		.49	PM 4138

OPERATION PROFILE

NAME <u>Norman Fletcher</u> ALC <u>CO-ALC</u> DATE <u>30 MAR 89</u> RCC <u>MANITGIV</u> SHEET <u>1</u> OF <u> </u>													
PCN MSN P/N		WCD <u>36204N</u>		WCD DATE <u>89069</u>		MANPOWER				EQUIPMENT			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
								%	HRS.		%	HRS.	
079 080	MAN PRC	MOVE	1.0	TRANSIT		OVHD UP05	1		.6	4		4	EXTORINAL MOVE T 36M
				SETUP							.6		
				PROCESS									
080 081	MAN PRC	CLN	1.0	TRANSIT		UP05	1		.05	1		.05	DECREASE T 3M S/P 6M
				SETUP									
				PROCESS							.1		
-	-	-	-	TRANSIT						1		.1	
				SETUP									
				PROCESS									
080 081	MAN PRC	PEEN BLST	1.0	TRANSIT		UP05	1		.05	1		.05	SHCT PEEN / MASK T 3M S 6M P 3M
				SETUP		UP05	1		.1	1	.1		
				PROCESS							.1		
-	-	-	-	TRANSIT									
				SETUP									
				PROCESS									
-	-	-	-	TRANSIT									
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME <u>NICHAN FETTER</u>		ALC <u>CO-ALC</u>		DATE <u>30 MAY 69</u>		RCC <u>MANPGW</u>		SHEET <u>2</u> OF <u> </u>					
PCN <u> </u>		NSN <u> </u>		WCD <u>36204N</u>		WCD DATE <u> </u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED HRS.	DATA SOURCE COMMENTS	
					MANDATORY FLOW HRS. %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.			
090	MAN PRC	CLN ANZZ	1.0	TRANSIT		UP05	1			PM 4118	1	.05	TU20
				SETUP		UP09	1			CE20	1	.05	T 3M
				PROCESS					PM 5021	1	.05	S 3M	
-	-	-	-	TRANSIT									
				SETUP					CE20	1	.05		
				PROCESS		UP09	1		PM 5021	1	.05		
090A	MAN PRC	RINS ANZZ	1.0	TRANSIT								RINSE	
				SETUP		UP09	1			CE20	1	.01	T/S IM
				PROCESS		UP09	1			CE20	1	.01	P IM
-	-	-	-	TRANSIT									
				SETUP					PM 5070	1	.01		
				PROCESS									
090B	MAN PRC	CLN ANZZ	1.0	TRANSIT								FORMULA PR	
				SETUP		UP09	1			CE20	1	.01	T/S IM
				PROCESS		UP09	1			CE20	1	.01	P IM

OPERATION PROFILE

NAME <u>NORMAN FLETCHER</u> ALC <u>CC-ALC</u> DATE <u>30 MAY 69</u> RCC <u>MANPCAN</u> SHEET <u>3</u> OF <u> </u>														
PCN NSM PIN														
WCD <u>36-2CAN</u> WCD DATE <u> </u>														
MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.		%	HRS.	
-	-	-	-	TRANSIT										
				SETUP										
				PROCESS										
DPDC	MAN PLC	RINSE ANALYZE	1.0	TRANSIT										RINSE T/S IM P IM
				SETUP			UP09	1						
				PROCESS			UP09	1						
				TRANSIT										
				SETUP										
				PROCESS										
090D	MAN PLC	DEOX ANALYZE	1.0	TRANSIT										DEOX T/S IM P 5M 2'S 10M 2'S
				SETUP			UP09	1						
				PROCESS			UP09	1	95	05			95	05
				TRANSIT										
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME NOIRMAN FLETCHER ALC COALC DATE 30 MARCH 79 RCC MANPGW SHEET 4 OF

WCD <u>36204N</u> WCD DATE _____																
PCN NSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
						MANDATORY FLOW HOURS %	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	HRS.		EQUIPMENT CODE	QTY.	TIME REQUIRED %	HRS.
090E	MAN PIC	RINS ANZZ	1.0	TRANSIT	---	---	---	---	---	---	---	---	RINSE T/S IM P IM			
				SETUP	---	---	UP09	1	---	.01	---	CE20		1	---	.01
				PROCESS	---	---	UP09	1	---	.01	---	CE20		1	---	.01
---	---	---	---	TRANSIT	---	---	---	---	---	---	---	---	---	---		
				SETUP	---	---	---	---	---	---	---	---	---		---	---
				PROCESS	---	---	---	---	---	---	---	---	---		---	---
090F	MAN PIC	ANZZ	1.0	TRANSIT	---	---	---	---	---	---	---	---	SULFURIC ANEDIZE T/S IM P 45M			
				SETUP	---	---	UP09	1	---	.01	---	CE20		1	---	.01
				PROCESS	---	---	UP09	1	---	.05	---	CE20		1	---	.05
---	---	---	---	TRANSIT	---	---	---	---	---	---	---	---	---	---		
				SETUP	---	---	---	---	---	---	---	---	---		---	---
				PROCESS	---	---	---	---	---	---	---	---	---		---	---
090G	MAN PIC	RINS ANZZ	1.0	TRANSIT	---	---	---	---	---	---	---	---	RINSE T/S IM P IM			
				SETUP	---	---	UP09	1	---	.01	---	CE20		1	---	.01
				PROCESS	---	---	UP09	1	---	.01	---	CE20		1	---	.01

PM 5702 1 .01

DR

OPERATION PROFILE

NAME NORMAN FLETCHER ALC CC ALC DATE 30 MAY 69 RCC MAN POW SHEET 5 OF

PCN NSN PM		WCD <u>36204N</u> WCD DATE _____												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.			
090H	MAN PCC	SEAL ANZ2	1.0	TRANSIT									SEAL T/S IM P 5M.95 15M.25	
				SETUP			UP09	1		.01	CE20	1		.01
				PROCESS			UP09	1	95 .05	CE20	1	95 .05		
-	-	-	-	TRANSIT					5 .10			5 .10		
				SETUP						PM 3673	1	95 .08		
				PROCESS							5 .25			
090I	MAN PCC	RINS ANZ2	1.0	TRANSIT									RINSE T/S IM P IM	
				SETUP			UP09	1		.01	CE20	1		.01
				PROCESS			UP09	1		.01	CE20	1		.01
-	-	-	-	TRANSIT							PM 5700	1	.01	
				SETUP										
				PROCESS										
090J	MAN PCC	RINS ANZ2	1.0	TRANSIT									RINSE, HOT T/S IM P IM	
				SETUP			UP09	1		.01	CE20	1		.01
				PROCESS			UP09	1		.01	CE20	1		.01

PM 5676 1 .01

OPERATION PROFILE

NAME <u>NORMAN FEEBEE</u>		ALC <u>DDALC</u>		DATE <u>30 MAY 69</u>		RCC <u>MANPGW</u>		SHEET <u>6</u> OF <u> </u>						
PCN <u> </u>		NSN <u> </u>		PIN <u> </u>		WCD <u>36204N</u>		WCD DATE <u> </u>						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.
000K	MAN PRC	PRY ANTZ	1.0	TRANSIT		UPR	1					DEMASK PRY, ALC T IM P ZM		
				SETUP										
				PROCESS										
001	PRA	MOVE	1	TRANSIT		OVHD	1							
				SETUP										
				PROCESS										
-	-	-	-	TRANSIT										
				SETUP										
				PROCESS										
-	-	-	-	TRANSIT										
				SETUP										
				PROCESS										
-	-	-	-	TRANSIT										
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME KERSTMAN ALC _____ DATE _____ RCC Brakes SHEET 1 OF 2

PCN 10735A WCD 36204N WCD DATE 89069

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.	
110	MAN P&P	INSP	1.0	TRANSIT			04HD	1		.01	FLOO1	1		.01	Transport	
				SETUP												
				PROCESS			Y409	1		.05	Pm0132	1		.05	Inspection	
1200		WASH	1.0	TRANSIT			3009	1		.01					Solvent	
				SETUP			3009	1		.01	Pm0436	1		.01	WASH	
				PROCESS							P0001	1		.01		
1201		MASK	1.0	TRANSIT											MASK	
				SETUP												&
				PROCESS			3009	1		.05	P0001	1		.05	Plug	
1202		PRIM	1.0	TRANSIT											Prime	
				SETUP		.35	3009	1		.02	Pm0138	1		.02	one side	
				PROCESS							P0001	1		.35	dry 20min	
120D		PRIM	1.0	TRANSIT											Prime	
				SETUP		1	3009	1		.02	Pm0438	1		.02	other side	
				PROCESS							P0001	1		1	dry 1 hr.	

F-15 Housing

OPERATION PROFILE

NAME Kerthman ALC _____ DATE _____ RCC _____ SHEET 2 OF 2

WCD 36204N WCD DATE 09069

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					SKILL CODE/LEVEL	QTY.	%	QTY.	EQUIPMENT CODE	QTY.	%	HRS.	
120E	1MAN REP	MASK	1.0	TRANSIT									Additional MASKING
				SETUP									
				PROCESS	3409	1		02	P1001	1		02	
120F		Paint	1.0	TRANSIT									1st Coat
				SETUP	3409	1		02	P100136	1		02	
				PROCESS					P1001	1		02	
120G		Paint	1.0	TRANSIT									2nd Coat & Dry this step begin approx 5min after previous step
				SETUP	3409	1		02	P100137	1		02	
				PROCESS					P1001	1		05	
130		UNLD	1.0	TRANSIT									UNLOAD & Inspect. 4 paper
				SETUP									
				PROCESS	4609	1		05	P100139	1		05	
200A		Rep	1.0	TRANSIT									Rebuild pistons & cylinders
				SETUP									
				PROCESS	4609	1		1.5	UN0006	1		1.5	

F-15 HOWERS

OPERATION PROFILE F 15 STEEL

NAME C. CIRCUMFORD ALG 00 DATE 5-30-85 RCC MAN PWW SHEET OF

WCD DATE 89073

WCD 363050

PCN 68235A

NSN PIN 18235 A		MANPOWER												EQUIPMENT		DATA SOURCE COMMENTS
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED			
					%	HRS.			%	HRS.						
50	MAN PWW	LOAD	1	TRANSIT												Load on Rack 1 Place in Furnace 10/8 Stack 20/LOAD
				SETUP												
				PROCESS			WFOB 6408	2	1.0	3	CE 24	1	1.0	3		
50A	MAN PWW	Bake	1	TRANSIT												HEAT UP IN OVEN
				SETUP												
				PROCESS						PM 6737	1	1.0	12.0			
50B	MAN PWW	UNLOAD	1	TRANSIT												REMOVE FROM OVEN
				SETUP												
				PROCESS			WFOB 6408	2	1.0	3	CE 24	1	1.0	3		
50C	MAN PWW	COOL DOWN	1	TRANSIT												AIR COOL DOWN
				SETUP												
				PROCESS	1.0	6.0										
50D	MAN PWW	UNLOAD	1	TRANSIT			WFOB 6408	2	1.0	3	CE 24	1	1.0	3		REMOVE FROM RACK BY HAND
				SETUP												
				PROCESS												

1.50-2000X

DR

OPERATION PROFILE

NAME KEPAPAN ALC 00 DATE 5-25-89 RCC Bales SHEET 1 OF

PCN 68735A WCD 36205N WCD DATE 89073

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.	Skill CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.		
150	MAN REP	Insp	1.0	TRANSIT											Inspect & load on paint-line	
				SETUP												
				PROCESS			3409	1		.02	Rm0922	1		.02		
160		Prim	1.0	TRANSIT											Prime & Dry	
				SETUP		1	3409	1		.02	Rm0922	1		1		
				PROCESS							Rm0438	1		.02		
160A		Prim	1.0	TRANSIT											1st coat	
				SETUP			3409	1		.01	Rm0922	1		.01		
				PROCESS							Rm0436	1		.01		
160B		Prim	1.0	TRANSIT											2nd coat and Dry	
				SETUP		.5	3409	1		.01	Rm0922	1		.5		
				PROCESS							Rm0437	1		.01		
170		UNLD	1.0	TRANSIT											UNLOAD & Unsp Insp	
				SETUP												
				PROCESS												

F-15 Backing plate

OPERA: PROFILE

DR

NAME <u>Turner</u>		ALC <u>00</u>	DATE <u>5-24-89</u>	RCC <u>MAN PRB</u>	SHEET <u>1</u> OF <u>1</u>						
PCN <u>68735A</u>		WCD <u>36205N</u>		WCD DATE <u>89073</u>							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
					SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.		QTY.	TIME REQUIRED %
60 88	MAN PRB	Resu	1.00	TRANSIT	JA09	1	02				
				SETUP	JA09	1	1.61	PM 6652	1	1.61	
				PROCESS	JA09	1	04	PM 6652	1	04	
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE S-31-89 RCC MANPGW SHEET 1 OF 2

WCD 36205N WCD DATE 89073

68735A

PCN
NSN
PIN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	
				TRANSIT								
				SETUP								
				PROCESS								
13	MAN PNA	MAG	1.0	TRANSIT		OVHD	1	.10	FL 0002	1	.10	
				PROCESS								
				PROCESS		DB09	1	.10	PM 6668	1	.10	
13A	MAN PNA	DEGR	1.0	PROCESS								
				PROCESS		DB09	1	.07	PM 3428	1	.07	
				TRANSIT								
				SETUP								
				PROCESS								
90	MAN PNA	MAG	1.0	PROCESS								
				PROCESS		DB09	1	.10	PM 6670	1	.10	

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 2

PCID
NSN
PM

WCD 36205A WCD DATE 89073

68735A

68735A																
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.	
				TRANSIT												
				SETUP												
				PROCESS												
130	MAN PNA	MAG	1.0	TRANSIT				1		.10	FL 0002	1		.10		
				PROCESS				1		.10	PM 6668	1		.10		
140	MAN PNA	DEGR	1.0													
				PROCESS				1		.07	PM 3428	1		.07		
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

OK

NAME Turner ALC OG DATE 5-24-89 RCC MANPRA SHEET 1 OF 1

WCD DATE 89673

WCD 36205 N1

68735A

[illegible]

157-1141

OPERATION PROFILE

NAME <u>Norman Fletcher</u> ALC <u>CO-ALC</u> DATE <u>30-MAR-79</u> RCC <u>MANICGV</u> SHEET <u>1</u> OF <u> </u>												
PCN <u>08735A</u> WCD <u>36205N</u> WCD DATE <u>09073</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
079 080	MAN PRC	MOVE	1.0	TRANSIT		UP05	1	.6	PM 4118	1	.6	EXTERNAL MOVE
				SETUP								
				PROCESS								
080 081	MAN PRC	CLN	1.0	TRANSIT		UP05	1	.05	PM 4118	1	.05	DECREASE T 3M
				SETUP								
				PROCESS								
082 083	MAN PRC	BLST	1.0	TRANSIT		UP05	1	.05	PM 4118	1	.05	GRIT BLAST / MASK T 3M
				SETUP								
				PROCESS								
084 085	MAN PRC	-	-	TRANSIT		UP05	1	.05	PM 4118	1	.05	GRIT BLAST / MASK T 3M
				SETUP								
				PROCESS								
086 087	MAN PRC	-	-	TRANSIT		UP05	1	.05	PM 4118	1	.05	GRIT BLAST / MASK T 3M
				SETUP								
				PROCESS								

OPERATIONAL PROFILE

NAME NEWMAN FUTURE ALC COALC DATE 30 MAY 69 RCC MANPGW SHEET 2 OF

PCN
NSN
PM

WCD 36205N

WCD DATE

OPERATION NUMBER	MCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
					MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED			EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%	HRS.			%	HRS.				%	HRS.
110A	MAN PREC	RINS PHAT	1.0	TRANSIT			UP05	1		PM 411B	1		.05	RINSE, HOT T 3M S 3M P 5M	
				SETUP			UP09	1		CE30	1		.05		
				PROCESS					PM 5675	1		.05			
	-	-	-	TRANSIT											
				SETUP					CE30	1		.05			
				PROCESS			UP09	1		PM 5675	1		.05		
110A	MAN PREC	PAM	1.0	TRANSIT										MANGANESE PHOSPHATE T/S 1M P 45m	
				SETUP			UP09	1		CE30	1		.01		
				PROCESS			UP09	1		CE30	1		.05		
				TRANSIT						PM 5694	1		.75		
				SETUP											
				PROCESS											
110B	MAN PREC	RINS PHAT	1.0	TRANSIT										RINSE T/S 1M P 1M	
				SETUP			UP09	1		CE30	1		.01		
				PROCESS			UP09	1		CE30	1		.01		

PM 5630 1 .01

ISC-200020

OPERATION PROFILE

NAME NORMAN FLETCHER ALC CCALC DATE 30 MAY 69 RCC MANPCW SHEET 3 OF

PCN
NSN
PM

WCD 26205N

WCD DATE

NSN	PM	MANPOWER														EQUIPMENT			DATA SOURCE COMMENTS
		OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED				
							%	HRS.			%	HRS.			%	HRS.			
		110B	MAN PRC	DIP PHAT	1.0	TRANSIT												CHROMIC DIP T/S IM P 2M	
						SETUP			UP09	1		.01	CE30	1		.01			
						PROCESS			UP09	1		.03	CE30	1		.03			
						TRANSIT							PM 5677	1		.03			
						SETUP													
						PROCESS													
		110D	MAN PRC	RINSE PHAT	1.0	TRANSIT												RINSE T/S IM P 1M	
						SETUP			UP09	1		.01	CE30	1		.01			
						PROCESS			UP09	1		.01	CE30	1		.01			
						TRANSIT							PM 5630	1		.01			
						SETUP													
						PROCESS													
						TRANSIT			UP09	1		.01	CE30	1		.01		DEMAX DIP, AIR T 1M P 2M	
						SETUP													
						PROCESS													
		110E	MAN PRC	PHAT DRY	1.0	TRANSIT			UP09	1		.03	CE30	1		.03			
						SETUP													
						PROCESS			UP09	1		.03	CE30	1		.03			

OPERATIONAL PROFILE

NAME: NORMAN FLETCHER ALC CO-ALC DATE 30 MAY 89 RCC MANPGW SHEET 4 OF 4

WCD 36205N										WCD DATE											
PCN	ASN	PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS					
								%	HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.		TIME REQUIRED				
												%	HRS.				%	HRS.			
120	MAN	PRC	BAKE	1.0	PHM	1.0	TRANSIT			UP05	1							BAKE 4118			
							SETUP			UP06	1									T 3M	
							PROCESS													S 3M	
	MAN	PRC	PHM		PHM		TRANSIT			UP05	1							DRYFILM LUGS 11182000			
							SETUP													NO 4118 BAKG	
							PROCESS			UP06	1										T 3M
	MAN	PRC	PHM		PHM		TRANSIT			UP05	1							SEAL 4118			
							SETUP														T 3M
							PROCESS			UP09	1										
	MAN	PRC	PHM		PHM		TRANSIT			UP05	1							SEAL 4118			
							SETUP														T 3M
							PROCESS			UP09	1										
121	PNA	MOVE	1	PHM		TRANSIT			DN10	1								SEAL 4118			
						SETUP														T 3M	
						PROCESS															S 13 7M

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

WCD 36208N												WCD DATE 89040			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.		QTY.	%	HRS.	QTY.	%	HRS.		
IS	MAN PGW	LOAD	1.0	TRANSIT											
				SETUP											
				PROCESS											
ISA	MAN PNA	FPI	.25	PROCESS			KI07	1		PM 0901	1		.05		
				TRANSIT					PM 0901	1		.02			
				PROCESS					PM 0901	1		1.10			
ISB	MAN PNA	FPI	.75	PROCESS			DB09	1		PM 0679E	1		1.10		
				TRANSIT					PM 0901	1		.02			
				PROCESS					PM 0901	1		1.05			
ISC	MAN PGW	UNLD	1.0	TRANSIT						PM 0901	1		.05		
				PROCESS					PM 0679E	1		1.05			
				PROCESS					PM 0901	1					

OPERATION PROFILE

DR

NAME C CRAWFORD ALC 00 DATE 6-8-87 RCC 00 SHEET 00 OF 00

WCD 362080 WCD DATE 89040

PCN 68735A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED %	QTY.	TIME REQUIRED %	
30	MAN PWW	TEST	1	TRANSIT							HARDNESS TEST
				SETUP							
				PROCESS	W508	1	1.0	05	1	1.0	
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

OPERATION PROFILE

NAME <u>MEL ANDERSON</u> ALC <u>00</u> DATE <u>5-31-89</u> RCC <u>MANPGW</u> SHEET <u>1</u> OF <u>1</u>												
WCD <u>36209A</u> WCD DATE <u>89040</u>												
68735A												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	MANPOWER QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
1S	MAN PGW	LOAD	1.0	TRANSIT								
				SETUP								
				PROCESS								
1SA	MAN PNA	FPI	.25	TRANSIT		KI07	1	.05	PM 0901	1	.05	
				PROCESS								
				PROCESS								
1SB	MAN PNA	FPI	.75	TRANSIT								
				PROCESS								
				PROCESS								
1SC	MAN PGW	UNLD	1.0	TRANSIT								
				PROCESS								
				PROCESS								

OPERATING PROFILE

DP

NAME <u>KEITHAN</u>		ALC <u>00</u>		DATE <u>00</u>		RCC		SHEET <u>1</u> OF <u>1</u>						
WCD <u>36209N</u>		WCD <u>36209N</u>		WCD DATE <u>89040</u>		EQUIPMENT		DATA SOURCE COMMENTS						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED	DATA SOURCE COMMENTS		
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.			EQUIPMENT CODE	QTY.
30	MAN POP	Insp	1.0	TRANSIT								Inspect & load paint line		
				SETUP										
				PROCESS										
040	}	MAK	1.0	TRANSIT								MAK		
				SETUP										
				PROCESS										
040A	}	PRIM	1.0	TRANSIT								PRIME		
				SETUP										
				PROCESS										
050	}	UND	1.0	TRANSIT								Final Insp & paperwork		
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

F-15 Torque tube

OPERATION PROFILE

NAME KESHAN ALC 00 DATE 00 RCC 00 00 SHEET 1 OF 1

WCD 36215N WCD DATE 89062

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS %	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %	
070	MAN 95R	Inst	1.0	TRANSIT							Clean & E&I
				SETUP							
				PROCESS		Y409	1		1	07	
070	MAN 95R	Rep	.90	TRANSIT							Repair channels & Rverts
				SETUP							
				PROCESS		Y409	1		1	08	
050	MAN 95R	Rep	.90	TRANSIT							Rvert channels
				SETUP							
				PROCESS		Y409	1		1	1	
060	MAN 95R	Inst	1.0	TRANSIT							Final Insp & paperwork
				SETUP							
				PROCESS		Y409	1		1	02	
				TRANSIT							
				SETUP							
				PROCESS							

F-15 Rotor

WR

OPERATION PROFILE

NAME Kernan ALC _____ DATE _____ RCC _____ SHEET 1 OF _____

WCD 36216N WCD DATE 890602

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					Skill Code/Level	QTY.	%	HRS.	Equipment Code	QTY.	%	HRS.	
010	MAN PAP	Imp	1.0	TRANSIT									E&I
				SETUP									
				PROCESS	Y609	1		05	WAD08	1		05	
040		Imp	1.0	TRANSIT									Final Imp & paperwork
				SETUP									
				PROCESS	Y609	1		01					
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

F-15 End Plate

DR

OPERATION PROFILE

NAME KEITHAN ALC _____ DATE _____ RCC _____ SHEET _____ OF _____

WCD 36217N WCD DATE 89069

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	MRS.	QTY.	%	QTY.	EQUIPMENT CODE	%	MRS.	
010	17512	TRIP	10	TRANSIT			1						Clean and F&I
				SETUP									
				PROCESS									
020		REPS	15	TRANSIT									Remove Rivets & Channels
				SETUP									
				PROCESS									
050		R.I.D	15	TRANSIT									Install & Rivet Channels
				SETUP									
				PROCESS									
060		TRIP	10	TRANSIT									Final Insp & Paper
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

F-15 Pressure plate

OPERATION PROFILE

JK

NAME <u>VERSTAN</u> ALC _____		DATE _____		RCC <u>BRATES</u>		SHEET _____ OF _____						
WCD <u>36218N</u>		WCD DATE <u>89069</u>		WCD <u>00235A</u>		WCD DATE <u>89069</u>						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MAN-POWER SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
010	MAN Rep	Imp	1.0	TRANSIT								Chen
				SETUP								
				PROCESS			1	.07	W4008	1	.07	EBI
020		Rep	.15	TRANSIT								Removal channels & Bunks
				SETUP								
				PROCESS			1	.08	D7001	1	.08	
030		Rep	.15	TRANSIT								River channels
				SETUP								
				PROCESS			1	.1	R7003	1	.1	
040		Imp	1.0	TRANSIT								Final Insp & paperwork
				SETUP								
				PROCESS			1	.02				
				TRANSIT								
				SETUP								
				PROCESS								

F-15 Station

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

WCD 36224N		WCD DATE 89065		WCD 68735 A		WCD 89065								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.		EQUIPMENT CODE	QTY.	%
15	MAN PGW	LOAD	1.0	TRANSIT										
				SETUP										
				PROCESS										
15A	MAN PNA	FPI	1.0	TRANSIT										
				PROCESS										
				PROCESS										
15B	MAN PNA	FPI	1.0	TRANSIT										
				PROCESS										
				PROCESS										
15C	MAN PGW	UNLD	1.0	TRANSIT										
				PROCESS										
				PROCESS										

OPERATIONAL PROFILE

1/2

NAME <u>Turner</u>		ALC <u>00</u>		DATE <u>5-24-89</u>		RCC <u>MAN PRA</u>		SHEET <u>1</u> OF <u>1</u>				
PCN <u>68375A</u>		WCD <u>36224 N</u>		WCD DATE <u>83065</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED % HRS.
30	MAN PRA	Modi	.50	TRANSIT		JA 10	1			PM 2576		
				SETUP		JA 10	1		PM 2576	1		.56
				PROCESS		JA 10	1		PM 2576	1		.67
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

11R

OPERATION PROFILE

NAME KESHAW ALC _____ DATE _____ RCC Brakes SHEET 1 OF _____

WCD 36236N WCD DATE 89061

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	%	HRS.	
020	MAN PAP	Insp	1.0	TRANSIT									Ed I stack & route
				SETUP									
				PROCESS		Y609	1		33 W10008	1		33	
060		Assy	1.0	TRANSIT									Assemble stack
				SETUP									
				PROCESS		Y609	1		17 W10008	1		17	
080		Insp	1.0	TRANSIT									Final Insp & paperwork
				SETUP									
				PROCESS		Y609	1		02				
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

- Disas

F-15 Hat stack bang

OPERATION PROFILE

NAME KEVIN ALC WCD DATE 8/20/04 RCC WCD SHEET 1 OF 2

WCD P36204 WCD DATE 8/20/04

68735A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	%			%	HRS.	
010A	MAN RGR	Dis	1.0	TRANSIT			Y609	1		.03						Disassemble Piston, Pin Adjuster Spring
				SETUP												
				PROCESS			Y609	1		.04		W40006	1			
020		CUN	1.0	TRANSIT			Y609	1		.03						disassemble & wipe clean
				SETUP												
				PROCESS			Y609	1		.04		W40006	1	50	.02	
030		Insp	1.0	TRANSIT												Inspected Piston, springs holders, pins, threaded bushings
				SETUP												
				PROCESS			Y609	1		.1		W40006	1		.1	
040		Rep	1.0	TRANSIT												Polish Adjuster Pin, springs holder
				SETUP												
				PROCESS			Y609	1		.04		W40006	1		.04	

F-15 Piston & Adjuster Assy
pseudo wcd # P36204

OPERATION PROFILE

NAME KERSTAN ALC DATE WCD P36204 RCC Brakes SHEET 2 OF 2

WCD P36204 WCD DATE 89200

68735A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	EQUIPMENT CODE	QTY.	%	HRS.	
050	MAN PGP	Inst	1.0	TRANSIT										Install seals to piston & sleeve
				SETUP										
				PROCESS			Y609	1					.05	
060		Asy	1.0	TRANSIT										Assemble piston, pin springs, adjuster etc
				SETUP										
				PROCESS			Y609	1					.06	
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

F-15 Piston & Adjuster Assy
Pseudo WCD # P36204

68735A F15A/B 5000913-14

RCC 13PNA

481-2-1123

OPER TECH S S W F F A/R REV

SUB	T K	#R	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A				
STEP	D	L	K	C	DC	ELEMENT	FACT	STOR	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C

2000	S	E	DB	EA	2	J	89096	1.00	PERCENT ENGR 99.9	NDI BRAKE F15 A/B	2.40		2.40		
0010			DB	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0020									WCD ROUTED PARTS REQUIRING FPI						
0030									5002269	1630001238806					
0040									5002227	1630003109835					
0050									GYS207-30W	5306002748753					
0060									GYS207-96W	5306002748754					
2001			DB	01	11			1.00		FPI 1ST TIME	1.317	.145	1.463	.8	61
0030	E							10.00	ZLG-ND-Z2	ZYGLO INSP MED PART BLD 507	.13177		1.462		
2017			DB	01	11			1.00		CONDUCTIVITY HOUSING	.068	.007	.076		3
0010	E							1.00	ZLG-ND-C1	SET UP CONDUCTIVITY METER	.03131		.034		
0020	E							3.00	ZLG-ND-C2	CONDUCTIVITY CHECK	.00121		.004		
0030	E							1.00	ZLG-ND-E5	MATERIAL HANDLING TEST AREA	.00371		.004		
0040	E							1.00	ZPL-PW-L1	ENTER INFO IN LOG BOOK	.01951		.021		
0050	E							1.00	RJP-PW-R1	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011		
2018			DB	01	11			1.00		HARDNESS TEST BRAKE HOUSING	.113	.013	.126		5
0010	E							.25	ZLG-ND-H1	SET UP HARDNESS MACH TYPE B PRORATE 4 PARTS	.12165		.033		
0020	E							2.00	ZLG-ND-H2	HARDNESS CHECK - ADDITIONAL	.03487		.077		
0030	E							1.00	ZLG-ND-E5	MATERIAL HANDLING TEST AREA	.00371		.004		
0040	E							1.00	RJP-PW-R1	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011		
2050			DB	01	00			.00		PART NUMBER/NSN	.000	.000	.000		0
0010									WCD ROUTED PARTS REQUIRING FPI						
0020									5002483	1630001322821					
2051			DB	01	11			1.00		FPI 1ST TIME	.662	.073	.736		31
0010	E							1.00	ZLG-ND-M6	MAGNAGLO INSP SMALL OBJECT	.09138		.101		
0020	E							1.00	ZLG-ND-M7	MAGNAGLO INSP MED. OBJECT	.20565		.228		
0030	E							1.00	ZLG-ND-M8	MAGNAGLO INSP LARGE OBJECT	.30816		.342		
0040	E							1.00	ZLG-ND-M2	MAGNETIZE WITH COIL	.01309		.014		
0050	E							1.00	ZLG-ND-M3	MAGNETIZE WITH CONTACT POINT	.01501		.016		
0060	E							1.00	ZLG-ND-M4	DEMAGNETIZE OBJECT AFTER INS	.01968		.021		
0070	E							1.00	RJP-PW-R1	REM RPL PAPRWRK SIGN OFF DOC	.01001		.011		
9000			DB	01	00			.01		LABOR STD HISTORY	.000	.000	.000		0
0010									DN GRADED TO N STD 8ADD DESGREASE TIME						
0020									OLD TIME WAS (.59)30MAY85						
0900									D.PARKER TECHN MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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WNPNA68735ANA205

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 04/17/89 A-E046B-MM1-DY-M45 PAGE 0001

68735A F15A/B BRK 5000913-14

RCC WNPNA

4B1-2-1123

OPER TECH S S W F PF A/R REV

SUB	T K	#R A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D L	K C	DC	ELEMENT	FACT	STORED	HOURS	TIME	HOURS	DLY PCT C

NA205	S	E	DB	EA 2	J 89103	1.00 PERCENT ENGR 99.9	NDI BACKING PLATE F15 A/B	.26		.26	
0001			DB	01	00	.00	PART NUMBER/NSN	.000	.000	.000	0
0010						5002483	1630001322821				
0090			DB	01	11	1.00	FMPI BACKING PLATE	.071	.008	.079	30
0010	E					ZLG-ND-M5	1.00 MAGNAGLO INSP V/S OBJECT	.06113		.067	
0020	E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC,	.01001		.011	
0130			DB	01	11	1.00	FMPI BACKING PLATE	.071	.008	.079	30
0010	E					ZLG-ND-M5	1.00 MAGNAGLO INSP V/S OBJECT	.06113		.067	
0020	E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC,	.01001		.011	
0140			DB	01	11	1.00	DEGREASE	.097	.011	.108	41
0010	E					RWB-CV-D1	1.00 VAPOR CL (DEGR)HOOK/BASKET	.08709		.096	
0020	E					RJP-PW-R1	1.00 REM RPL PAPRWRK SIGN OFF DOC	.01001		.011	
9000			DB	01	00	.00	LABOR STD HISTORY	.000	.000	.000	0
0010							10JUN85 CHANGED SKL CODE NO 7M CHNG				
0020							01JUL85 ADDED N&B TIME (7M WAS 1.01)				
0900							D.PARKER TECHN MANEAA				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC MPMME

8/18/89
481-2-1123

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89109

68733A MACHINE RIVETS

TECH S S H F PF A/R REV

T K R A FA SUPPORT

STEP D L K C DC ELEMENT

OCC

FACT

STORED

DESCRIPTION

SUPPLEMENTAL

BASE
HOURS

PFD
TIME

STD
HOURS

A
DLY PCT C

ME215	S	E	JN	EA	1	H	89095	2.55	PERCENT ENGR	99.9	MACH RIVETS F-15 A/B ROTOR	.42		1.00		
0001			JN	01	00			.00			PART NUMBER/NSN	.000	.000	.000		0
0010								5005072			1630010030444					
0020			JN	01	15			1.00			REMOVE RIVETS & RETAINERS	.371	.056	.427		100
0010	E					RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE			PRORATE OVER 4 PARTS	.49962		.143		
0020	E					RLA-HP-C1	1.00	1ST PART IN-OUT SCROLL CHUCK				.01006		.011		
0030	E					KML-7D-HA	1.00				REMOVE RIVETS & RETAINERS	.22607		.259		
0040	E					RJP-PW-R1	1.00	REM RPL PAPHRK SIGN OFF DOC				.01001		.011		
9000			JN	01	00			1.00			LABOR STD HISTORY	.000	.000	.000		0
0900											LLOYD A. HARGIS MANEL-1					73357

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

05/03/69

A-52468-MM1-DY-M45

PAGE 0001

68735A

MACHINE RIVETS

RCC CHNPME

481-2-1123

39189

OPER TECH S S W F FF A/R REV

SUB	T K	#R A F4	SUPPORT	DOC	DESCRIPTION	BASE	PRD	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORER	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

ME217	S	E	JN	EA	1	H	89101	.10	PERCENT ENGR	99.9	MACH RIVETS F-15 A/B BRAKE	.42		.04	
0001			JN	01	00			.00			PART NUMBER/NSN	.000	.000	.000	0
0010											5005069				
0020			JN	01	15			1.00			1630010829734	.371	.356	.427	100
0010 E								.25	SET UP SMALL MEDIUM LATHE		PRORATE OVER 4 PARTS	.49962		.143	
0020 E								1.00	1ST PART IN-LET SCROLL CHUCK			.01006		.011	
0030 E								1.00	REMOVE RIVETS & RETAINERS			.22607		.259	
0040 E								1.00	REM RPL PAPERWORK SIGN OFF DOC			.01001		.011	
0000			JN	01	00			1.00	LABOR STD HISTORY			.000	.000	.000	0
0990									LLOYD A. HARGIS MANEL-1		73357				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRCP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

05/03/89

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RCC MMNPME

481-2-1123

89109

68735A MACHINE RIVETS

OPER	TECH	S S	W F	PF	A/R	REV													A
SUB	T K	R A	FA	SUPPORT	DOC		DESCRIPTION			BASE	REF	STD							
STEP	D L	K C	DC	ELEMENT	FACT		STORED		SUPPLEMENTAL	HOURS	TIME	HOURS							DLY PCT
ME218	S	E	JN	EA 1	H	S9095	.20	PERCENT ENGR 99.9	MACH RIVETS F-15 A/B STATOR	.42			.28						
0001			JN	01	00		.30		PART NUMBER/NSN	.000	.000	.000							0
0010							5005075		1633010827467										
0020			JN	01	15		1.00		REMOVE RIVETS & RETAINERS	.371	.056	.427							100
0010	E					RLA-SU-S3	.25	SET UP SMALL MEDIUM LATHE	PRORATE OVER 4 PARTS	.49962			.143						
0020	E					RLA-HP-D1	1.00	1ST PART IN-OUT SCROLL CHUCK		.01006			.011						
0030	E					KML-TD-HA	1.00		REMOVE RIVETS & RETAINERS	.22607			.259						
0040	E					RJP-PW-R1	1.00	REM RPL PAPERWK SIGN OFF DOC		.01001			.011						
9000			JN	01	00		1.00		LABOR STD HISTORY	.000	.000	.000							0
0900									LLOYD A. HARGIS MANEL-1 73357										

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRCP NR

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78735AMG204

LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS
RCC INPMG

04/17/89
481-2-1203

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89107

68735A EDM HOUSING										RCC INHMS		481-2-1100		1100	
TECH S S		M F PF A/R REV		OCC <		DESCRIPTION		BASE		PFD		STD		A	
SUB		T K		#R A FA SUPPORT		FACT		STORED		SUPPLEMENTAL		HOURS		DLY PCT C	
STEP D L		K C DC ELEMENT													
MG204	E	N	JB	EA	1	J	89103	.25	PERCENT ENGR	.0			.20		.05
0001			JB	01	00			.00					.000	.000	.000
0010									5002269						
0060			JB	01	00			1.00					.200	.000	.200
0010 N								1.00					.20000		.200
9000			JB	01	25			.01					.000	.000	.000
0010									06JUN85 CHANGED SKL CODE NO TM CHNG						
0020									03JUL85 ADDED NICK & BURR TIME (TM WAS .30)						
0900									D.PARKER TECHN MANEAA						

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

04/17/89

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68735A F15A/B BRK 5000913-14

RCC MNPRA

481-2-1123

83027

OPER TECH S S W F PF A/R REV

SUB	T K	NR A FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A	
STEP	D L	K C	DC ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY FCT C

RA204	S	E	JA	EA 1	J	89103	.25	PERCENT ENER 99.9	MACH HOUSING ASSY F15A/B	1.80		.45	
0001			JA	01	00		.00		PART NUMBER/NSN	.000	.000	.000	0
						5002269			1630001238806				
0030			JA	01	15		1.00		MACH FACE OF HOUSING	.640	.096	.737	41
0010	E				KYM-SU-V1		.25	S/U VERT MILL BORE SMAL FXTMPORATE OVER 4 PARTS		.50518		.145	
0020	E				RML-PP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030	E				RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040	E				RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.057	
0050	E				RML-BA-CD		1.00	BORE HOLE 2 X 2 GROUP 1	USE PROPER ELEMENT/TABLE	.21626		.248	
0060	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0040			JA	01	15		1.00		REIDENTIFY	.099	.015	.114	6
0010	E				RBW-SU-G1		.25	S/U FOR BENCH WORK GENERAL PRORATE OVER 4 PARTS		.27525		.079	
0020	E				GID-SA-A1		1.00	STAMP WITH METAL STAMP		.00342		.003	
0030	E				GID-SA-A2		9.00	STAMP W/METAL STAMP ADDL NINE ADDITIONAL NUMBERS		.00187		.019	
0040	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0050			JA	01	15		1.00		REMOVE PITTING	.029	.004	.034	2
0010	E				RSG-JP-05		1.00	PREP HAND DRILL CHANGE 1 BIT		.01603		.018	
0020	E				RBW-BU-P1		1.00	BUTTERFLY POLISH BUSHING I D		.00333		.003	
0030	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0070			JA	01	15		1.00		REMOVE INSERTS	.314	.047	.362	20
0010	E				RBW-SU-G1		.50	S/U FOR BENCH WORK GENERAL PRO RATE 2 PARTS		.27525		.153	
0020	E				JLR-AS-DB		6.00	RMVE SMALL SPRING W/TWEELERS6 INSERTS		.01232		.085	
0030	E				GTL-TH-A1		6.00	TAP HOLE TO 0.25 IN THRD DIA6 INSERTS		.01427		.098	
0050	E				GCL-CA-A4		6.00	CLEAN BLIND HOLE WITH AIR 6 INSERTS		.00126		.008	
0060	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0100			JA	01	15		1.00		REPLACE INSERTS	.486	.073	.560	31
0010	E				RBW-SU-H1		1.00	SET UP TO INSTALL HELICOILS		.31093		.357	
0020	E				RBW-TR-H1		6.00	INSTALL HELICOIL INSERT 6 INSERTS		.02763		.190	
0030	E				RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			JA	00	15		.00		LABOR STANDARD HISTORY;	.000	.000	.000	0
0010									13MAY86-INITIAL INPUT-NEEDS MORE WORK;				
0900									KERRY COOP TECH MANEAA 73357-73783				

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NRG? NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS

04/17/69

A-E046B-MM1-DY-M45 PAGE 0001

68735A F15A/B BRK 5000913-14

RCC MNPRA

481-2-1123

83027

OPER TECH S S W F PF A/R REV

SUB	T K	NR A FA	SUPPORT	QCC	DESCRIPTION	BASE	PFD	STD	A	
STEP D L	K C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY PCT C

RA205	S	N	JA	EA	1	J	89103	.50	PERCENT ENGR 73.6	MACH BACKING PLATE F15A/B	4.21		2.10	
0001			JA	01	00			.00		PART NUMBER/NSN	.000	.000	.000	0
0010									5002483	1630001322821				
0030			JA	01	15			1.00		O/S HOLE ON MILL/MED PART	1.698	.255	1.953	46
0010 E						RML-SU-V2		.25	S/U VERT MILL BORE LRG FIXTRPRGRATE OVER 4 PARTS		.80167		.230	
0020 E						RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E						RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E						RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 E						KMM-BA-AA		7.00	BORE HOLE 1 X 1/2 GROUP 1 7 TERMINAL HOLES		.17132		1.379	
0060 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0040			JA	01	15			1.00		O/S HOLE ON MILL/MED PART	.981	.147	1.129	27
0010 E						RML-SU-V2		.25	S/U VERT MILL BORE LRG FIXTRPRGRATE OVER 4 PARTS		.80167		.230	
0020 E						RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E						RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E						RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 N								1.00	RADIUS BOTH SIDES		.48300		.555	
0060 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
0070			JA	01	15			1.00		O/S HOLE ON MILL/MED PART	.981	.147	1.129	27
0010 E						RML-SU-V2		.25	S/U VERT MILL BORE LRG FIXTRPRGRATE OVER 4 PARTS		.80167		.230	
0020 E						RML-HP-CA		1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098	
0030 E						RML-AL-AB		1.00	ALIGN VERTICAL AXIS ROD		.12699		.146	
0040 E						RML-AL-AC		1.00	ALIGN HOLE TO SPINDLE ROD		.07609		.087	
0050 N								1.00	RADIUS BOTH SIDES		.48300		.555	
0060 E						RJP-PW-R1		1.00	REM RPL PAPRWRK SIGN OFF DOC		.01001		.011	
9000			JA	00	00			.00		LABOR STANDARD HISTORY;	.000	.000	.000	0
0010									13MAY86-INITIAL INPUT-NEEDS MORE WORK;					
0900									KERRY COOP TECH MANEAA 73357-73787					

TO INTERROGATE LABOR STANDARDS, INPUT

RCC PRD NROP NR

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LABOR STANDARD OPERATION RESOURCE STANDARD AND METHOD ANALYSIS 04/17/89 A-E046B-MM1-DY-M45 PAGE 0001
68735A F15 A4B BRK500913-14 RCC MNPRE 481-2-1123 083-0445 86078

OPER	TECH	S	S	W	F	PF	A/R	REV	SUB	T	K	NR	A	FA	SUPPORT	OCC	DESCRIPTION	BASE	PFD	STD	A
STEP	D	L	K	C	DC	ELEMENT	FACT	STORED	SUPPLEMENTAL	HOURS	TIME	HOURS	DLY	PCT	C						
RB205	S	E	JA	EA	3	J	89103	.10	PERCENT ENGR	99.9	GRIND BACKING PLATE F15A/B	1.55		.18							
0001			JA	01	00		.00		PART NUMBER/NSN		.000	.000	.000	0							
0010							5002483		1630001322821												
0060			JA	01	15		1.00		RESURFACE PLATE		1.610	.242	1.853	100							
0010	E					RGR-SU-S1	1.00	SET UP SURFACE GRINDER		.04390		.050									
0020	E					RML-HP-CA	1.00	HAND HANDLE NO WRAP 2 CLAMPS		.08531		.098									
0030	E					KMG-DW-OD	1.00	DRESS EXTERNAL WHEEL		.02308		.026									
0040	E					KMG-SW-LK	1.00	LOCATE WHEEL TO POSITION		.06761		.077									
0050	E					KMG-OD-WA	2.00	GRIND .010 FROM 18 IN OD X 1 BOTH SIDES		.57151		1.314									
0060	E					RGR-GE-D2	18.00	DWELL (GAP GRINDER STEEL OD) OCC FOR DIA		.01014		.209									
0070	E					RTL-M-M3	9.00	MIC O D FIRST MEASUREMENT 3 PLACES 3 CHECKS		.00616		.063									
0080	E					RJP-PW-R1	1.00	REM RPL PAPHRK SIGN OFF DOC		.01001		.011									
9000			JA	01	00		.00		LABOR STANDARD HISTORY		.000	.000	.000	0							
0010							9 JUNE 88	INITIAL INPUT MRPII													
0900							NED MONROE	MANEL	73255	MR BIS											

INTERROGATE LABOR STANDARDS, INPUT

RCC FRD NROP NR

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OPERATION PROFILE

F-16 BRAKE-HOUSING ASSY (ALUM)

NAME <u>D. DIVELOISS</u> ALC <u>SS</u> DATE <u>18 JUN 89</u> RCC <u>MANPGW</u> SHEET <u>1</u> OF <u>3</u>		WCD <u>37201N</u> WCD DATE <u>820719</u>												
NSN <u>25874A</u>		MANPOWER					EQUIPMENT							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SHELL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
								%	HRS.			%	HRS.	
5	MAN PGW	DIS	1.000	TRANSIT										REM. PISTON ASSY
				SETUP										
				PROCESS										
6	MAN PGW	LOAD	1.000	TRANSIT										B.H. CONV.
				SETUP										
				PROCESS										
7	MAN PGW	CLN	1.000	TRANSIT										CHEM LINE
				SETUP										
				PROCESS										
8	MAN PGW	LINULO	1.000	TRANSIT										AUT. 0626 6634
				SETUP										
				PROCESS										
9	MAN PGW	CLN	1.000	TRANSIT										O.H. CONV. TO KULLER CONV.
				SETUP										
				PROCESS										
9	MAN PGW	CLN	1.000	TRANSIT										BIAS
				SETUP										
				PROCESS										

OPERATION PROFILE

F-16 BRAKE - HOUSING ASSY (AKUM)

NAME D. DAVENBISS ALC CC DATE 10/4/88 RCC MANPGW SHEET 2 OF 3

WCD 37201N			WCD DATE 89079																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
OPERATION NUMBER	NOC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																													
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19	MAN PGW	Proc	1.000	TRANSIT								NICK & BURN.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
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				PROCESS		KIOS	1	90	.75	Pm0410	1		90	.25																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																													

OR

OPERATION PROFILE

F-16 BRACKET - HOUSING ASSY (A1)

NAME D. DUBOISS ALC 00 DATE 06 JUN 89 RCC MANAGER SHEET 3 OF 3

WCD 37201N WCD DATE 88079															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
									%	HRS.			%		HRS.
19B MAN PEN		LOAD	1.00	TRANSIT											TO BELT CONVEYOR
				SETUP											
				PROCESS											
20 MAN PEN		INSP	1.00	TRANSIT											E & I
				SETUP											
				PROCESS											
20A MAN PEN		STACK	1.00	TRANSIT											TO PALLET
				SETUP											
				PROCESS											
20B OVHD PEN		MOVE	1.00	TRANSIT											MOVE TO MACHINE SHOP
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

ECN 25874A WCD 3720IN WCD DATE 89079

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.			%	HRS.			%	HRS.	
15	MAN PNA	FPI	.75	TRANSIT											
				SETUP											
				PROCESS											
				PROCESS PROCESS											
15A	MAN PNA	FPI	.25	TRANSIT											
				PROCESS PROCESS											
				PROCESS											
				PROCESS											
15B	MAN PGW	UNLD	1.0	TRANSIT											
				PROCESS PROCESS											
				PROCESS											
				PROCESS											

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OPERATION PROFILE

NAME Turner ALC 00 DATE 5-24-89 RCC MAN PRA SHEET 1 OF 3PCN 25874A WCD 37201N WCD DATE 89079

25874A

PN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
						%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%
30	MAN PRA	Remo	.11	TRANSIT			JA 08	1		.02				Bench OP	
				SETUP			JA 08	1		.28		1			.28
				PROCESS			JA 08	1		.21		1			.21
40	MAN PRA	Remo	.50	TRANSIT			JA 08	1		.02				Bench OP	
				SETUP			JA 08	1		.50		1			.50
				PROCESS			JA 08	1		.42		1			.42
50	MAN PRA	MACH	.43	TRANSIT			JA 11	1		.02					
				SETUP			JA 11	1		.50		1			.50
				PROCESS			JA 11	1		.35		1			.35
60	MAN PRA	Remo	.05	TRANSIT			JA 08	1		.02				Bench OP	
				SETUP			JA 08	1		.05		1			.28
				PROCESS			JA 08	1		.40		1			.40
70	MAN PRA	Modi	.61	TRANSIT			JA 11	1		.02					
				SETUP			JA 11	1		.56		1			.56
				PROCESS			JA 11	1		.29		1			.29

Bench
OPBench
OPBench
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OPERATION PROFILE

SHEET 2 OF 3

RCC

DATE

ALC

NAME

WCD DATE

WCD

PCN
NSN
PIN

KSN	PM	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS										
		OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED			
							%				HRS.	%			HRS.	%	HRS.	
80	MAN PRA	Mach.	.61	TRANSIT		JA 11	1		.02									
				SETUP		JA 11	1		.51		7216 PM	1						
				PROCESS		JA 11	1		.48		7216 PM	1						
90	MAN PRA	Drill	.61	TRANSIT		JA 09	1		.02								Bench OP	
				SETUP		JA 09	1		.01			1						
				PROCESS		JA 09	1		.23			1						
120	MAN PRA	Inst.	.97	TRANSIT		JA 09	1		.02								Bench OP	
				SETUP		JA 09	1		.31			1						
				PROCESS		JA 09	1		.54			1						
130	MAN PRA	Inst.	.05	TRANSIT		JA 09	1		.02								Bench OP	
				SETUP		JA 09	1		.28			1						
				PROCESS		JA 09	1		.09			1						
140	MAN PRA	Inst.	.61	TRANSIT		JA 09	1		.02								Bench OP	
				SETUP		JA 09	1		.28			1						
				PROCESS		JA 09	1		.26			1						

OPERATION PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 3 OF 3

PCN NSN P/N		WCD		WCD DATE		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		QTY.	TIME REQUIRED % HRS.
								%	HRS.		
150	MAN	Inst.	50	TRANSIT		IA09	1				
	SETUP				IA09	1					
	PROCESS				IA09	1					
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

Bench
OP

OPERATION PROFILE

NAME <u>NOBMAN FLETCHER</u> ALC <u>CO-ACC</u> DATE <u>30 MAY 69</u> RCC <u>MANIPUL</u> SHEET <u>1</u> OF <u> </u>															
PCN NSN PM		WCD <u>37201N</u>		WCD DATE <u>89079</u>		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.				
095	MAN PRC	MOVE	1.0	TRANSIT		OVHD UPCS	1	.6	PM 411B	1	.6	EXTERNAL MOVE			
				SETUP											
				PROCESS											
100 095A & 100B	MAN PRC	CLN		TRANSIT		UPCS	1	.05	PM 411B	1	.05	DECREASE T 3M			
				SETUP											
				PROCESS											S/P 6M
-	-	-	-	TRANSIT					PM 5620	1	.1				
				SETUP											
				PROCESS											
100A	MAN PRC	PEEN BEST		TRANSIT		UPCS	1	.05	PM 411B	1	.05	SHUT PEEN / MASK T 3M			
				SETUP											
				PROCESS											S/GM P 3M
-	-	-	-	TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME NICHAN FETTER ALC EX-ALC DATE 30 MAY 69 RCC MANPGW SHEET 2 OF

PCN NSN PIN														WCD 3720 IN				WCD DATE				EQUIPMENT				DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		EQUIPMENT	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS							
					%	HRS.		QTY.	%	HRS.	%			HRS.	%			HRS.									
11D	MAN PREC	CLN ANZZ	1.0	TRANSIT			UP05	1			.05	PM 4118	1						.05	TU20							
				SETUP			UP09	1			.05	CE20	1						.05	T 3 M							
				PROCESS								PM 5001	1						.05	S 3 M							
-	-	-	-	TRANSIT																							
				SETUP								CE20	1														
				PROCESS			UP09	1			.05	PM 5001	1							.05	P 5 M						
11DA	MAN PREC	RINS ANZZ	1.0	TRANSIT																RINS							
				SETUP			UP09	1			.01	CE20	1							.01	T/S IM						
				PROCESS			UP09	1			.01	CE20	1							.01	P IM						
-	-	-	-	TRANSIT								PM 5070	1														
				SETUP																							
				PROCESS																							
11DB	MAN PREC	CLN ANZZ	1.0	TRANSIT																FORMULA PR							
				SETUP			UP09	1			.01	CE20	1							.01	T/S IM						
				PROCESS			UP09	1			.01	CE20	1							.01	P IM						

OPERATION PROFILE

NAME NORMAN FLETCHER ALC CC-ALC DATE 30 MAY 69 RCC MANPCAW SHEET 3 OF

PCN NSN P/N			WCD <u>37201N</u> WCD DATE _____											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.			
-	-	-	-	TRANSIT										
				SETUP										
				PROCESS										
110C	MAN PLC	RINS ANALZ	1.0	TRANSIT									RINSE T/S IM P IM	
				SETUP	UP09	1	.01	CE20	1	.01				
				PROCESS	UP09	1	.01	CE20	1	.01				
-	-	-	-	TRANSIT										
				SETUP										
				PROCESS										
110D	MAN PLC	DEOX ANALZ	1.0	TRANSIT									DEOXIDEIZE T/S IM P 5M 2.5 10M .05	
				SETUP	UP09	1	.01	CE20	1	.01				
				PROCESS	UP09	1	.95	PM 5707	1	.95				
-	-	-	-	TRANSIT										
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME NUZMAN FLETCHER ALC COALC DATE 30-MAY-79 RCC MANPGW SHEET 4 OF

PCN NSN P/N			WCD <u>37201N</u> WCD DATE _____												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
					MANDATORY FLOW HOURS %	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	HRS.		EQUIPMENT CODE	QTY.	TIME REQUIRED %	HRS.
110 E	MAN PIC	RINS ANZZ	1.0	TRANSIT									RINSE T/S IM P IM		
				SETUP				UP09	1		.01	CEZ0		1	.01
				PROCESS				UP09	1		.01	CEZ0		1	.01
-	-	-	-	TRANSIT											
				SETUP											
				PROCESS											
110 F	MAN PIC	ANZZ ANZZ	1.0	TRANSIT									SULFURIC ANODIZE T/S IM P 45m		
				SETUP				UP09	1		.01	CEZ0		1	.01
				PROCESS				UP09	1		.05	CEZ0		1	.05
-	-	-	-	TRANSIT											
				SETUP											
				PROCESS											
110 G	MAN PIC	RINS ANZZ	1.0	TRANSIT										RINSE T/S IM P IM	
				SETUP				UP09	1		.01	CEZ0	1		.01
				PROCESS				UP09	1		.01	CEZ0	1		.01
PM 5702 1 .01															

OPERATION PROFILE

NAME NUQUAN FLETCHER ALC CC ALC DATE 30 MAR 68 RCC MANP6W SHEET 5 OF

PCN NSN P/N															WCD 37201N										WCD DATE									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	MANPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS																	
					%	HRS.			%	HRS.	%	HRS.			%	HRS.																		
110 H	MAN PCC	SEAL ANZL		TRANSIT													SEAL																	
				SETUP			UP09	1			.01		1		.01	T/S IM																		
				PROCESS			UP09	1	95	.05		1	95	.05	P 5M-25 15M 25																			
-	-	-	-	TRANSIT							5	.10			5	.10																		
				SETUP							PM 5673	1	95	.08																				
				PROCESS									5	.25																				
110 I	MAN PCC	RINS ANZL		TRANSIT													RINSE																	
				SETUP			UP09	1			.01		1		.01	T/S IM																		
				PROCESS			UP09	1			.01		1		.01	P IM																		
-	-	-	-	TRANSIT									PM 5700	1		.01																		
				SETUP																														
				PROCESS																														
110 J	MAN PCC	RINS ANZL		TRANSIT													RINSE, HOT																	
				SETUP			UP09	1			.01		1		.01	T/S IM																		
				PROCESS			UP09	1			.01		1		.01	P IM																		

PM 5676 1 .01

OPERATION PROFILE

NAME NIRVANFEER ALC IC-ALC DATE 30 MAY 89 RCC MANPGW SHEET 62 OF

PCN
NSN
PIN

WCD 37201N

WCD DATE

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	QTY.	%	HRS.	
110K	MAN PRC	DRY ANZZ	1.0	TRANSIT			UP27	1		.01	1		.01	DEMASK DRY, ALC T IM P 2M
				SETUP										
				PROCESS			UP27	1		.13	1		.03	
111	PRC	MOVE	1	TRANSIT			DXHD	1		.6	1		.6	
				SETUP										
				PROCESS										
---	---	---	---	TRANSIT										
				SETUP										
				PROCESS										
---	---	---	---	TRANSIT										
				SETUP										
				PROCESS										
---	---	---	---	TRANSIT										
				SETUP										
				PROCESS										

OPERATION PROFILE

NAME KERSHAW ALC Brakes RCC Brakes SHEET 1 OF 3

WCD 3720 N WCD DATE 89079

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	%			%	HRS.	
160	MAN REP	Insp	1.0	TRANSIT			DUHD	1		.01		F10001	1		.01	Transport
				SETUP												
				PROCESS			Y409	1		.05		Pm0932	1		.05	Inspection
170		WASH	1.0	TRANSIT			3009	1		.01						Solvent
				SETUP			3009	1		.01		Pm0436	1		.01	WASH
				PROCESS								P10001	1		.01	
170A		mask	1.0	TRANSIT												mask
				SETUP												Plug
				PROCESS			3009	1		.05		P10001	1		.05	
170B		prim	1.0	TRANSIT												Prime one side
				SETUP		.35	3009	1		.02		Pm0438	1		.02	dry 2amin
				PROCESS								P10001	1		.35	
170C		Prim	1.0	TRANSIT												Prime other side
				SETUP		1	3009	1		.02		Pm0438	1		.02	dry 1 hr.
				PROCESS								P10001	1		1	

F-16 Housing

DR

OPERATION PROFILE

NAME <u>KEITHAN</u>		ALC		DATE		RCC		SHEET <u>2</u> OF <u>25</u>				
WCD <u>37201N</u>		WCD DATE <u>87079</u>										
PIN <u>25874A</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	DATA SOURCE COMMENTS
170D	MAN REP	MARK	1.0	TRANSIT SETUP PROCESS		3409	1	.02	P1001	1	.02	Additional masking
170E		PAIR	1.0	TRANSIT SETUP PROCESS		3409	1	.02	P10136	1	.02	1st coat
170F		PAIR	1.0	TRANSIT SETUP PROCESS	5	3409	1	.02	P10001	1	.02	2nd coat & Dry
170G		UND	1.0	TRANSIT SETUP PROCESS		4409	1	.05	P10001	1	.05	UNLOAD & Inspect. 4 paper
200A	REP	REP	1.0	TRANSIT SETUP PROCESS		4409	1	.05	P10001	1	.05	Reload photos & checked

F-16 Housing

1.5

1.5C-3000X

OPERATION PROFILE

NAME KEPHTAW ALC DATE RCC Drakes SHEET 3 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.		EQUIPMENT CODE
180	PPR	Acpt	1.0	TRANSIT								Acceptance of paperwork
				SETUP								
				PROCESS								
190		Insp	1.0	TRANSIT								Final Visual Insp
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

F-16 housing

OPERATION PROFILE

F-16 Brake - Tongue Tulse - Steel

NAME <u>D. DIVELEISS</u> ALC <u>CS</u> DATE <u>12 Jul 89</u> RCC <u>MIANOGW</u> SHEET <u>1</u> OF <u> </u>		WCD <u>37202N</u>		WCD DATE <u>880440</u>		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
								%	HRS.			%	HRS.	
5	MAN PGW	DIS	1.000	TRANSIT										REM Foreign Mat'l
				SETUP										
				PROCESS			1	1000	.01	W800001	1	1000	.01	
5a	MAN PGW	Stack	1.000	TRANSIT										on Pallet
				SETUP										
				PROCESS			1	100	.02					
5b 9a	MAN PGW	Load	1.000	TRANSIT										Load near Hooks
				SETUP										
				PROCESS			1	100	.08	Pm7432	1	500	.08	
9	MAN PGW	CLN	1.000	TRANSIT										Photo/Slast
				SETUP			1	.02	.01					
				PROCESS	1.000									
9b	MAN PGW	UNLD	1.000	TRANSIT										UNLD - Meat - Hooks
				SETUP										
				PROCESS			1	100	.08	Pm7432	1	500	.08	

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OPERATION PROFILE

F-16 BRIDGE - BRIDGE TURN - STEEL

NAME D. Dineen ALC 00 DATE 12 JUN 89 RCC MANPSW SHEET 2 OF 3

PCN

NSN

PM

25874A

WCD 37202N

WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED	DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	SKILL CODE/LEVEL	TIME REQUIRED	EQUIPMENT CODE	QTY.	%	
9C	MAN PSW	STACK	1.00	TRANSIT	%							ON PALLET
				SETUP	HRS.							
				PROCESS								
9D	OVHD PSW	MOVE	1.00	TRANSIT								TO FPI
				SETUP								
				PROCESS								
13A	MAN PSW	UNLO	1.00	TRANSIT								O.H. DOWN TO KORTEL CONV.
				SETUP								
				PROCESS								
15	MAN PSW	INSP		TRANSIT								E&F
				SETUP								
				PROCESS								
15B	MAN PSW	STACK	1	TRANSIT								ON PALLET
				SETUP								
				PROCESS								

1.5C-300020

OPERATION PROFILE

F-16 BRIDGE - TORQUE TUBE (S/S)

NAME D. DIVERS ALC 00 DATE 12 JUN 89 RCC 17ANPgw SHEET 3 OF 3

WCD 37202N WCD DATE 89070

25874A

OPERATION NUMBER		RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
						%	QTY.	%	MRS.	QTY.	EQUIPMENT CODE	%	MRS.		
15B	OVHO Pgw	MOVE	1.00	TRANSIT										TO N & B	
				SETUP											
				PROCESS											
19	MAN Pgw	Proc	.20	TRANSIT										Newt & Burn	
				SETUP											
				PROCESS											
19B	MAN Pgw	Stru	.20	TRANSIT										on pallet	
				SETUP											
				PROCESS											
19C	OVHO Pgw	MOVE	1.00	TRANSIT										TO STR, 13 Prior to Paint	
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

WCD 37202N WCD DATE 89040

25874A

PCN
NSN
PIN

PM 25874A		EQUIPMENT												DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS		
					MANDATORY FLOW HOURS	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED				
					%	HRS.					%	HRS.			
13	MAN PNA	MAG	1.0	TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT			OVHD	1		FL 0002	1		.10		
				PROCESS			DB09	1		PM 6668	1		.10		
13A	MAN PNA	DEGR	1.0	TRANSIT											
				SETUP											
				PROCESS			DB09	1		PM 3428	1		.07		.07
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

12 June 83
WR

OPERATION PROFILE

F-16 BRAKE - BASKING PLATE (STEEL)

NAME <u>D. Divelbiss</u>		ALC <u>09</u>		DATE <u>12 Jun 83</u>		RCC <u>MANPGW</u>		SHEET <u>1</u> OF <u> </u>																	
WCD <u>37203N</u>		WCD <u>25874A</u>		WCD DATE <u>830400</u>																					
OPERATION NUMBER		RCC		OPERATION DESCRIPTION		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE		MANDATORY FLOW HOURS		SKILL CODE/LEVEL		QTY.		TIME REQUIRED %		EQUIPMENT CODE		QTY.		TIME REQUIRED %		DATA SOURCE COMMENTS	
5		MAN PGW		Dis		1.00		TRANSIT																REM. Foreign MTL	
5A		MAN PGW		Stack		1.00		TRANSIT																On Pallet	
5B		MAN PGW		Load		1.00		TRANSIT																Load on MEAT Hooks	
9		MAN PGW		CLN		1.00		TRANSIT																ROTO BLAST	
9B		MAN PGW		UNLO		1.00		TRANSIT																MEAT Hooks to Pallet	

TO 401-2-163

15C-211120

OPERATION PROFILE

F-16 BRIDGE - (Backing Plate (Steel))

NAME D. Dwyer ALC 00 DATE 12 Jun 89 RCC PLANESW SHEET 2 OF 2

WCD 37203N WCD DATE 880710

25874A

PCN
1000
PIN

PM 200T4A															
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE		QTY.	%	HRS.
90	OVHD RW	MOVE	1.00	TRANSIT									MOVE TO Cold Flatten # 25A		
				SETUP											
				PROCESS											
				TRANSIT			OVHD	1	100.00	FL90003	1	100.00			
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

STEEL

NAME C. GREGG ROSS AL0 00 DATE 5-30-89 RCG MAN (PWS) SHEET OF

WCD 372030

WCD DATE 89040

PCN 25874A

OPERATION NUMBER	RCG	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
20	MAN PWS	LOAD	1	TRANSIT								Load 013
				SETUP								Back 1
				PROCESS		WFOB	2	1.0 3	CE 24	1	1.0 3	Place 12
20A	MAN PWS	BACK	1	TRANSIT								Remove 30/STACK
				SETUP								60/LAND
				PROCESS								HEAT 40 IN OVEN
20B	MAN PWS	UNLOAD	1	TRANSIT					PM 5737	1	1.0 12.0	
				SETUP								REMOVE FABR OVEN
				PROCESS		WFOB	2	1.0 3	CE 24	1	1.0 3	
20C	MAN PWS	COOL DOWN		TRANSIT								AIR COOL DOWN
				SETUP								
				PROCESS	1.0 6.0							
20D	MAN PWS	UNLOAD	1	TRANSIT		WFOB	2	1.0 3	CE 24	1	1.0 3	REMOVE FROM RACK
				SETUP					LE 24	1	1.0 3	By hand
				PROCESS					LE 24	1	1.0 3	

1502000X

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE S-31-89 RCC MANPGW SHEET 1 OF 1

PCN
NSN
PIN

WCD 37203A WCD DATE 89040

25874A

25874A														
NSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	
					TRANSIT									
					SETUP									
					PROCESS									
30	MAN PNA	MAG	1.0		TRANSIT			OVHD	1		.10	FL 0002	1	.10
					PROCESS			DB09	1		.10	PM 6668	1	.10
30A	MAN PNA	DEGR	1.0											
					PROCESS,			DB09	1		.07	PM 3428	1	.07
					TRANSIT									
					SETUP									
					PROCESS									
					TRANSIT									
					SETUP									
					PROCESS									

1.5C-200020

OPERATION PROFILE

NAME <u>KERSTAL</u>		ALC		DATE		RCC		SHEET <u>2</u> OF <u>2</u>							
PCH		WCD		WCD		WCD		WCD							
MSN		37203N		37203N		37203N		37203N							
PIN		25874A		25874A		25874A		25874A							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
070	PR	Aspt	1.0	TRANSIT											Acceptance of paperwork
				SETUP											
				PROCESS			Y609	1		.02					
080	}	Insp	1.0	TRANSIT										Final Visual Inspection	
				SETUP											
				PROCESS			Y609	1		.02					
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

F-16 Backing plate

Dr

NAME <u>Kershner</u>		ALC	DATE	RCC	SHEET <u>Pages</u> OF												
WCD <u>37209N</u>		WCD DATE <u>89060</u>															
WCD <u>25874A</u>																	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED	DATA SOURCE COMMENTS					
					%	HRS.	QTY.	%	HRS.	QTY.			%	HRS.			
010	MAN PAP	Ingr	1.0	TRANSIT								Data's Clean and F&I. per plate					
				SETUP													
				PROCESS													
015	MAN PAP	MACH	.80	TRANSIT								Remove channels					
				SETUP													
				PROCESS													
017	MAN PAP	MACH	.05	TRANSIT								oversize River Hole					
				SETUP													
				PROCESS													
035	MAN PAP	Pond	.80	TRANSIT								Re-Pond					
				SETUP													
				PROCESS													
040	MAN PAP	Ingr	1.0	TRANSIT								Final Insp & paperwork					
				SETUP													
				PROCESS													

F-16 Poton

15" x 15" x 15"

OPERATION PROFILE

DR

NAME <u>KERMAN</u> ALC _____		DATE _____		RCC _____		SHEET _____ OF _____							
WCD <u>37205N</u>		WCD DATE <u>99060</u>											
WCD <u>25874A</u>		WCD DATE <u>99060</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS.	DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	HRS.	EQUIPMENT CODE			
005	MAN POP	TAP	1.0	TRANSIT									Disassemble Clean & E&I
				SETUP									
				PROCESS			Y409	1		07	1	07	
015		MACH	10	TRANSIT									Remove Rivets & Channel
				SETUP									
				PROCESS			Y409	1		1	1	1	
035		Rivet	10	TRANSIT									Re-Rivet
				SETUP									
				PROCESS			Y409	1		08	1	08	
040		TAP	1.0	TRANSIT									Final Insp
				SETUP									
				PROCESS			Y409	1		02	1	02	

F-16 pressure plate

OPERATION PROFILE

NAME KEPSTHAN ALC _____ DATE _____ RCC _____ SHEET _____ OF _____

WCD 372060N WCD DATE 89060

WCD 25874

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
						BILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	
005	MAN PAP	Inp	1.0	TRANSIT								Disassembly clean E & I
				SETUP								
				PROCESS								
015	~	mach	.20	TRANSIT								Repair Rivers & Channels
				SETUP								
				PROCESS								
035	~	River	.20	TRANSIT								De-River
				SETUP								
				PROCESS								
040	~	FISH	1.0	TRANSIT								Final Impact
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

F-16 station

112

OPERATION PROFILE

NAME <u>Keshava</u>		ALC		DATE		RCC		Brakes		SHEET 1 OF 2					
WCD <u>37207N</u>		WCD <u>25874 A</u>		WCD DATE <u>8800</u>		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS					
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.					
010	MAN REP	Insp	1.0	TRANSIT SETUP PROCESS			Y609	1				1			Disassy Clean E&I
015		mach	1.0	TRANSIT SETUP PROCESS			Y609	1				1			Remove Rivets & Channels
035		Rivet	1.0	TRANSIT SETUP PROCESS			Y609	1				1			Re-Rivet
040		Acpt	1.0	TRANSIT SETUP PROCESS			Y609	1				1			Accept paperwork
050		Inspr	1	TRANSIT SETUP PROCESS			Y609	1				1			Final Visual Inspr

F-16 End pit

OPERATION PROFILE

NAME KEITHAN ALC _____ DATE _____ RCC _____ Bakes SHEET 2 OF 2

NSN 25874A WCD 37207N WCD DATE 89060

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	QTY.	%	
050A	P&P	Imp	9	TRANSIT									Final Usual Inspect.
				SETUP									
				PROCESS			4609	1			02		
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME Kershaw ALC DATE 37208N WCD 37208N RCC Brakes SHEET 89060 OF 1

WCD 37208N			WCD DATE 89060												
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.
010	MAN PGP	MATCH	1.0	TRANSIT										MATCH CAP	
				SETUP											
				PROCESS											
030		ARM	1.0	TRANSIT										AC Inspected assemble	
				SETUP											
				PROCESS											
040		ACPT INSP	1.0	TRANSIT										Final t approve	
				SETUP											
				PROCESS											
050		INSP		TRANSIT										Final Usual INSP	
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

F-16 Heat Stack Assy
(Assembly only)

012

OPERATION PROFILE F-16 BRAKE - HEAT STACK ASSY

NAME D. DIVELEISS ALC 00 DATE 12 Jun 89 RCC MANRSW SHEET 1 OF 1

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	EQUIPMENT CODE	QTY.	TIME REQUIRED %	
5	MAN R&W	MARK	1.00	TRANSIT							MARK HIGHWAY OF HEAT - STACK
				SETUP							
				PROCESS	H805	1	100.00	W80001	1	100.00	
5A	MAN R&W	STACK	1.00	TRANSIT							on Pallet
				SETUP							
				PROCESS	H805	1	100.00				
005B 10	OUM R&W	MOVE	1.00	TRANSIT							To STA-13 CARBON/STEP
				SETUP							
				PROCESS	0V40	1	100.00	FLO003	1	100.00	
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

T.O. 481.2-1162 / 1163 / 1164

DR

OPERATION PROFILE

F-16 BRAKE ASSY

NAME D. DINEEN ALC 00 DATE 10 JUN 89 RCC MANPGW SHEET 1 OF 1

WCD 37209N WCD DATE 88040 WCD 25874A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.			%	HRS.			%	HRS.	
1	MAN PGW	IND	1.00	TRANSIT											
				SETUP											
				PROCESS											
5	MAN PGW	DIS	1.00	TRANSIT			HB05	1							
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

DR

NAME KERSHAW ALC 00 DATE 5-24-89 RCC Brakes SHEET 1 OF 2

PCN 25874 A WCD 37209N WCD DATE 89040

OPERATION NUMBER		RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
						%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.	
10	MAIN PGP	MTLH	1.0	TRANSIT												MATCH UP
				SETUP												
				PROCESS												
20	}	TRIP	1.0	TRANSIT												PRE Assembly Inspection
				SETUP												
				PROCESS		Y609	1		2	W0005	1			.2		
30	}	ASSY	1.0	TRANSIT												ASSY
				SETUP												
				PROCESS		Y609	1		1	W0005	1			1		
40	}	TEST	1.0	TRANSIT												Test
				SETUP		Y609	1		35	PM0449	1			.35		
				PROCESS						PM0464	1			.35		
50	}	DEAL	1.0	TRANSIT												DEAL SP.
				SETUP												
				PROCESS		Y609	1		00	PM0433	1					

F-16 Brake Assy

OK

OPERATION PROFILE

NAME: <u>Kerstman</u>		ALC		DATE		RCC		SHEET <u>2</u> OF <u>2</u>							
WCD <u>37209N</u>		WCD DATE <u>89040</u>		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		QTY.	TIME REQUIRED			
					%	HRS.			%	HRS.		%	HRS.		
060	POP	Acpt	1.0	TRANSIT										Acceptance of paperwork	
				SETUP											
				PROCESS											
070	INS	Insp	1.0	TRANSIT										Final Visual Insp.	
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

F-16 Brake Assy

OPERATION PROFILE

NAME KEVIN W ALC. DATE WCD P37201 RCC 7GP - Bolcks SHEET 1 OF 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.		
010A	MAN 7GP	Dis	1.0	TRANSIT				Y609	1							Disassembly (Seal & Retainer) - Piston Assy
				SETUP												
				PROCESS				Y609	1		W0006	1			.01	
020A		Test	1.0	TRANSIT												Test Grip & Pin Subassy
				SETUP												
				PROCESS				Y609	1		W0006	1			.02	
030A		Dis	1.0	TRANSIT												Disassemble Piston Assy and sleeve Assy
				SETUP												
				PROCESS				Y609	1		W0006	1			.04	
040A		CAN	1.0	TRANSIT				Y609	1							Degrease & wire Clean
				SETUP												
				PROCESS				Y609	1		P00H34	1		50	.02	
				TRANSIT							P00H21	1		50	.02	
				SETUP							W0006	1			.02	
				PROCESS												

F-16 Piston & sleeve Assembly
Poured WCD # P37201

6 per brake Assy

OPERATION PROFILE

BR

NAME KEBETHAN ALC DATE WCD P3720 RCC Books SHEET 2 OF 3

PCN 25874A WCD P3720 WCD DATE 8920

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	QTY.	%	QTY.	EQUIPMENT CODE	%	HRS.	
050A	MTR REF	Imp	1.0	TRANSIT									Inspect & prepare parts
				SETUP									
				PROCESS			1			W10006		05	
060A		Ref	1.0	TRANSIT									Repair damaged threads
				SETUP									
				PROCESS			1			W10006		04	
070A		Asy	1.0	TRANSIT									Install seals and assemble (Piston Assy)
				SETUP									
				PROCESS			1			W10006		1	
080A		Ref	1.0	TRANSIT									Hone cylinder Repair damage to turds
				SETUP									
				PROCESS			1			W10006		08	
090A		Imp	1.0	TRANSIT									Inspect cylinder bore spring
				SETUP									
				PROCESS			1			W10006		03	

Piston Assy

Cable Assy

F-16 Piston & Sleeve Assemblies
P5UCDO WCD# P37201

OPERATION PROFILE

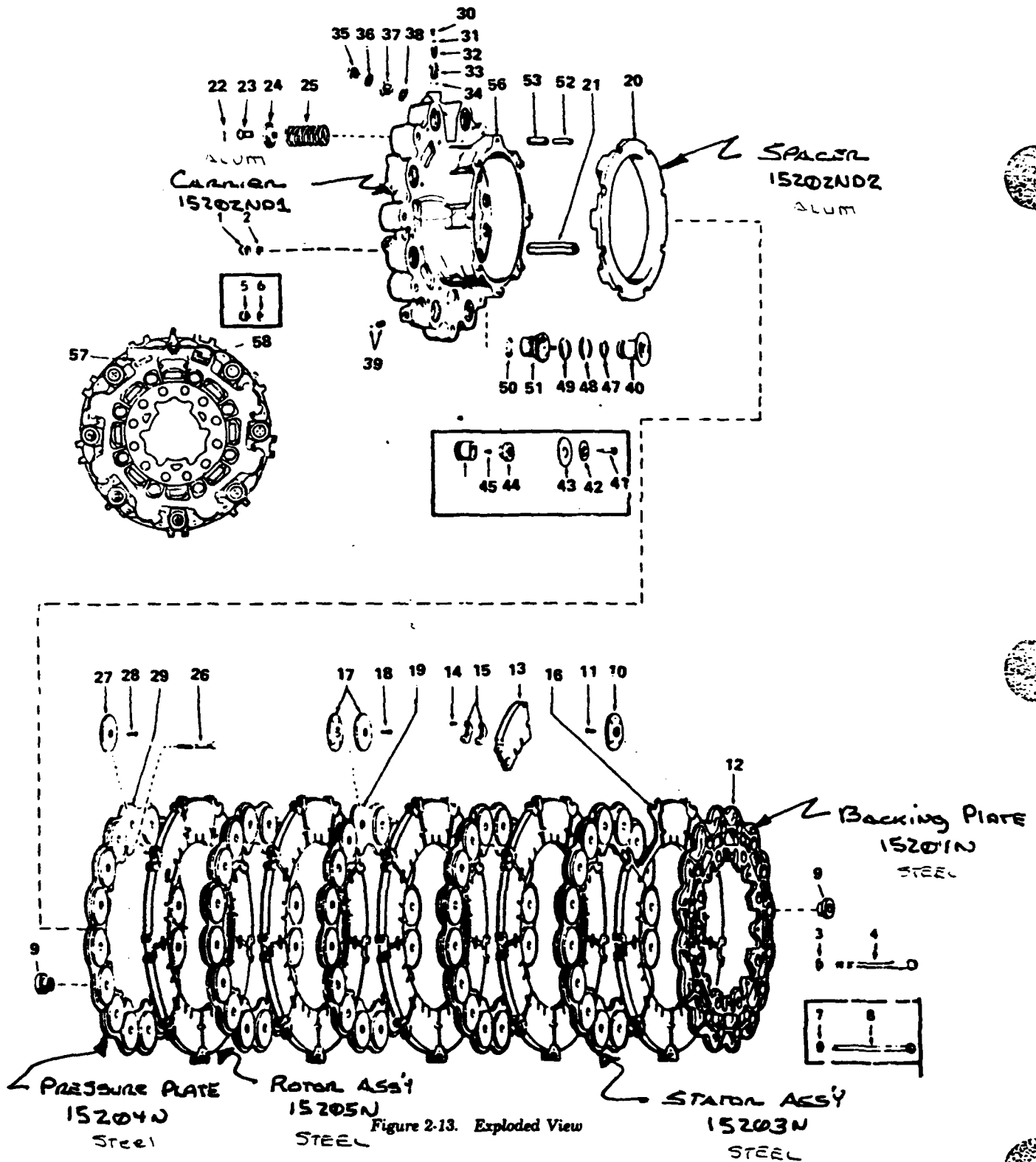
Steve Assy

NAME <u>KERSTAN</u>		ALC		DATE		RCC		SHEET <u>3</u> OF <u>3</u>						
PCN <u>25874</u>		WCD <u>P37201</u>		WCD DATE <u>8/20/00</u>										
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	EQUIPMENT CODE		QTY.	TIME REQUIRED %	HRS.
100A	PSP	Assy	1.0	TRANSIT								Assembl wipac, etc sprng, etc to Steve		
				SETUP										
				PROCESS			4609	1			02		wipac	1
110A		Assy	1.0	TRANSIT								Assembl Piston Assy and Steve Assy, Fuelbox etc		
				SETUP										
				PROCESS			4609	1			08		wipac	1
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

F-16 piston & Steve Assy's
Powed Wed# P37201

KC-135 Brake Assy

WCO 15202N



Pages 2-24A and 2-24B are deleted in their entirety.

2-11. **FEDERAL SUPPLY CODES FOR MANUFACTURERS (FSCM).** The following codes are in accordance with H4-1, H4-2, and H4-3 Cataloging Handbook, Federal Supply Codes for Manufacturers.

CODE NAME AND ADDRESS

06848 Allied Signal Inc
DBA Allied-Signal Aerospace Co
717 N Bendix Dr
South Bend, IN 46620

14892 Bendix Corporation
The Brake and Steering Div
401 N Bendix Dr
PO Box 4001
South Bend, IN 46634

21849 Nasco Aircraft Brake Inc
13300 Estrella Ave
Gardena, CA 90247

55284 Allied Signal Inc
DBA Allied Signal Aerospace Co
Bendix Wheels and Brake Div
3520 Westmoor St
PO Box 10
South Bend, IN 46624

CODE NAME AND ADDRESS

72902 Greene Tweed and Co Inc
Div Denton Industrial Pk
25 Engerman Ave
Denton, MD 21629

72962 Elastic Stop Nut
A Div of Harvard Industries, Inc
2330 Vauxhall Road,
Union, NJ 07083 -5038

88044 Aeronautical Standards Group
Dept of Navy and Air Force

92555 The Lee Co
2 Pettipaug Rd
PO Box 424
Westbrook, CT 06498-1543

96906 Military Standards

97945 Pennwalt Corp
SS White Industrial
Products Division
151 Old New Brunswick Rd
Piscataway, NJ 08854-3708

98747 OO-ALC
Hill AFB, UT 84056

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-13-	2600380-1		BRAKE ASSEMBLY, (5 Rotor)..... (2600380/06848)	1	A	XC
	2600380-2	55284	BRAKE ASSEMBLY, (5 Rotor)..... (2600945/06848)	1	B	PAODD
	149499-4	55284	BRAKE ASSEMBLY, (4 Rotor)..... (2600212/06848)	1	C	PAODD
-1	1801-070	72962	NUT, Self-locking, hex 7/16-20..... (alternate 145380/06848)	8	C	PAFZZ
-2	AN960-716	88044	WASHER, Flat..... (alternate 911251/06848)	8	C	PAFZZ
-3	MS20002C7	96906	WASHER, Recessed (alternate..... 158562/06848)	8	C	PAFZZ
-4	149610	14892	BOLT, Special 7/16-20 by 5-15/16..... Inch	8	C	PAFZZ
-5	1801-070	72962	NUT, Self-locking, hex 7/16-20..... (alternate 145380/06848) (alternate part No. F1080-070U)	8	A,B	PAFZZ
-6	AN960-716	88044	WASHER, Flat..... (alternate 911251/06848)	8	A,B	PAFZZ
-7	AN960-716	88044	WASHER, Flat..... (alternate 911251/06848)	8	A,B	PAFZZ
-8	154853	55284	BOLT, Machine.....	8	A,B	PAFZZ
-9	153223	55284	WASHER, Shouldered and recessed..... (repair only) (AP)	AR		PADBZ
	150929	55284	BACKING PLATE ASSEMBLY..... (alternate 150625 or 2601844)	1	C	PAFDD
	2160207	55284	BACKING PLATE ASSEMBLY.....	1	A,B	PAFDD
	2601844	55284	BACKING PLATE ASSEMBLY.....	1	A,B	PAFDD
-10	357080	55284	LINING, Cerametallic.....	16		PAFZZ
-11	MS20427-6C7	96906	RIVET, Solid (steel) (alternate..... (steel) MS20427F6-7/96906, 152216/06848) (AP)	16		PAFZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-13-12	149625	•								1		XA
	150934	•								1		XA
	2601843	•								1		XA
	149618	•	55284							5	A,B	PAFFF
	149618	•	55284							4	C	PAFFF
-13	149620	•								9		XA
	2604262	•								9		XA
	2603251-2	•								9		XA
-14	150344	•	06848							27		MFFZZ
-15	152291	•								18		XA
	2604236	•								18		XA
	2605304	•								18		XA
-16	149619	•								1		XA
	2602213	•								1		XA
	2605303	•								1		XA
	150624	•	55284							4	A,B	PAFFF
	150624	•	55284							3	C	PAFFF
-17	357080	•	55284							32		PAFZZ
-18	MS20427-6C7	•	96906							16		PAFZZ
-19	149623	•								1		XA
-20	2600387	•	55284							1	A,B	PADDD
-21	2600386	•	55284							8	A,B	PAFBZ
	149611	•	55284							8	C	PAFBZ
-22	AN380-2-1	•	96906							7		PAFZZ
-23	2600237	•	06848							7		PAFBZ
-24	2600336	•	55284							7		PAFBZ
-25	149918	•	55284							7		PAFBZ
-26	2600238	•	55284							7		PAFBZ
	2601854	•	55284							1		PAFFF
-27	357080	•	55284							16		PAFZZ
-28	MS20427-6C7	•	96906							16		PAFZZ

FIG & INDEX NO.	PART NUMBER	FSCM	DESCRIPTION 1 2 3 4 5 6 7	UNITS PER ASSY	USABLE ON CODE	SMR CODE
2-13-29	2600343		. . PLATE, Pressure.....	1		XA
	2601853		. . PLATE, Pressure.....	1		XA
	2600381		. CARRIER ASSEMBLY.....	1	A	XC
	2600938		. CARRIER ASSEMBLY, (Service replacement for 2600211)	1	B,C	XA
	146937	55284	. . BLEEDER SCREW ASSEMBLY.....	1		PAOZZ
-30	MS35207-261	96906	. . SCREW, Machine (alternate 902370K1/06848)	1		PAOZZ
-31	MS35338-43	96906	. . WASHER, Lock (alternate 901004K1/06848)	1		PAOZZ
-32	146938		. . SCREW, Bleeder.....	1		XA
-33	146936	55284	. . ADAPTER, Bleeder screw.....	1		PAFZZ
-34	MS28778-3	96906	. . PACKING, Preformed (alternate 147031/06848)	1		PAFZZ
-35	1604-78	97945	. . PLUG, Shipping (alternate 59361/06848)	1		PAOZZ
-36	69197	55284	. . GASKET, Cork.....	1		PAFZZ
-37	145405	55284	. . BUSHING, Machine.....	1		PAFBZ
-38	174S22	06848	. . GASKET, Copper.....	1		PAFZZ
-39	281101		. . PLUG, Fluid passage (alternate 353518-22)	8		XC
	291101	92555	. . PLUG, Fluid passage (oversize) (alternate 953518-24/06848)	AR		PADZZ
-40	2600383		. . PISTON ASSEMBLY.....	8	A	XC
	2600973	06848	. . PISTON AND HEAT SHIELD ASSEMBLY, (Alternate 513502)	8	B,C	PAFBZ
-41	149609		. . PIN, Insulator hold down.....	8		XB
-42	149293		. . COVER, Insulator.....	8		XB
-43	2600814	55284	. . SHIELD, Piston heat.....	8	B,C	PAFBZ
-44	2600384		. . INSULATOR PISTON.....	8		XB
-45	149629		. . INSERT PISTON.....	8		XB
-46	149479		. . PISTON, (Alternates 65203 and 153373)	8		XA
-47	721F6MR 160A T	72902	. . PACKING ASSEMBLY, (Optional part No. MS28775-216/96906)	8		PAFZZ
-48	148492	55284	. . RETAINING, Ring.....	8		PAFZZ
-49	153490	55284	. . WIPER, Piston.....	8		PAFZZ
-50	MS28775-222	96906	. . PACKING, Preformed.....	8		PAFZZ
	7027448-01	98747	. . PACKING, Preformed (oversize).....	AR		PAFZZ
-51	2600288	55284	. . BUSHING, Machine thread.....	8		PAFBZ
-52	MS16562-72	96906	. . PIN, Spring.....	8		PAFBZ
-53	MS16562-90	96906	. . PIN, Spring.....	8		PAFBZ
	8745810-01	98747	. . BUSHING REPAIR (Not illustrated).....	AR		PAFZZ
	8745810-08	98747	. . BUSHING REPAIR (Not illustrated).....	AR		PAFZZ
-54	Deleted					
-55	Deleted					
-56	2600209		. . CARRIER.....	1		XA
-57	147631		. DECAL, Fluid.....	1		MF
-58	40726		. DECAL, Nameplate.....	1		MF

*Nonprocurable except as part of next higher assembly.

FIGURE & INDEX NUMBER	PART NUMBER	FSCM	DESCRIPTION							UNITS PER ASSY	USABLE ON CODE	SMR CODE
			1	2	3	4	5	6	7			
2-13-51	2600288	55284	.	.	.	BUSHING, Machine thread.....				8		PAFBZ
-52	MS16562-72	96906	.	.	.	PIN, Spring.....				8		PAFBZ
-53	MS16562-90	96906	.	.	.	PIN, Spring.....				8		PAFBZ
	8745810-01	98747	.	.	.	BUSHING REPAIR (Not illustrated).....				AR		PAFZZ
	8745810-08	98747	.	.	.	BUSHING REPAIR (Not illustrated).....				AR		PAFZZ
-54	Deleted											
-55	Deleted											
-56	2600009		.	.	.	CARRIER.....				1		XA
-57	147631		.	.	.	DECAL, Fluid.....				1		MF
-58	40726		.	.	.	DECAL, Nameplate.....				1		MF
*Nonprocurable except as part of next higher assembly.												

KC-135

Brake Assembly

KC-135

Brake Assembly

PCN 15162A

WCD 15202N

Backings Plate

PCN 15162A

WCD 15201N

(P/N 149225)

Carrier

PCN 15162A

WCD 15202ND1

(P/N 2600209)

Spacer, B.P.

PCN 15162A

WCD 15202ND2

(P/N 2600387)

Stator Assy

PCN 15162A

WCD 15203N

(P/N 150624)

Pressure Plate

PCN 15162A

WCD 15204N

(P/N 2600343)

Rotor Assy

PCN 15162A

WCD 15205N

(P/N 149265)

8 JUN 89

KC135 BRAKE ASSY

pg 1 of 2

BACKING PLATE: 15201N Steel

- 10 DIS (REMOVE LININGS)
- 10A STACK (ON PALLET) E
- 20A LOAD (ROTO BLAST MEAT HOOKS)
- 20 CLN (ROTOBLAST)
- 20B UNLD (UNLOAD ROTOBLAST & STACK ON PALLET)
- 20C MOVE (FILM DIS TO E & I)
- 30- Insp
- 30A STACK (LOAD PALLET & DO PAPERWORK)
- 30B MOVE (FILM E & I TO HEAT TREAT)

CARRIER PLATE: 1520201 ALUM

- 1 REM (CYLINDER & SLEEVES)
- 1A REM (SMALL PIN)
- 1B REM (LARGE PIN)
- 1C REM (HEAT SHIELD)
- 2A LOAD (OVER HEAD CONVEYOR)
- 2 CLN (STRIP ON CHEM CLEAN LINE)
- 2B UNLOAD (OVERHEAD CONVEYOR) - in Blast area - goes TO FPI
- 2C MOVE (FROM E & I TO MACHINE SHOP)
- (3 REM (BROKEN SCREWS & TAPS)
- (10 Insp (FPI)
- 20- PROC Nick & Burr
- 30 Insp (E & I)

SPACER: 1520202

- 2A LOAD (OVERHEAD CONVEYOR)
- 2 CLN (STRIP ON CHEM CLN LINE)
- (2B MOVE (TO FPI PROCESS)
- (3 FPI
- 3A MOVE (TO Nick & Burr)
- 3A UNL (CONVEYOR TO CONV.)
- 4 PROC (Nick & Burr)
- 4B LOAD (PALLET)
- 5 Insp E & I

8 Jun 89

pg 2 of 2

KC-BRAKE ASSY (CONTINUED)

STATOR ASSY 15203N

10 DIS (REMOVE LINERS)
 10A STACK (ON PALLET)
 20A LOAD (ROTO BLAST MEAT HOOK)
 20 CLN (ROTO BLAST) ✓
 20B UNL (UNLOAD ROTOBLAST & LOAD ON PALLET)
 20C MOVE (FROM DIS TO E & I)
 30 INSP (E & I)
 30A LOAD (PALLET & PAPERWORK)
 30B MOVE (FROM E & I TO HEAT TREAT)

PRESSURE PLATE ASSY 15204N

10 DIS (REMOVE LINERS)
 10A STACK (ON PALLET)
 20A LOAD (ROTO BLAST MEAT HOOKS)
 20 CLN (ROTO BLAST)
 20B UNLD (ROTOBLAST & STACK ON PALLET)
 20C MOVE (FROM DIS TO E & I)
 30 INSP (E & I)
 30A STACK (LOAD PALLET & DO PAPERWORK)
 30B MOVE (FROM E & I TO HEAT TREAT)

ROTOR ASSEMBLY 15205N

1 DIS (REMOVE CLIPS)
 1A STACK (ON PALLET & DO PAPERWORK)
 1B MOVE (FROM DISC TO BLAST MACH)
 2 CLN (BLAST)
 2A STACK (ON PALLET & PAPERWORK)
 2B MOVE (FROM BLAST TO E & I)
 2 INSP (E & I)
 2A STACK (PALLET & PAPERWORK)
 2B MOVE (FROM E & I TO MACHINING SHOP)

OPERATION PROFILE

KC-135 BRAKE ASSY

NAME D. DINESS ALC 00 DATE 8 JUN 89 RCC MANREGW SHEET 1 OF 1

WCD <u>152022N</u>		WCD DATE <u>89040</u>												
MANPOWER		EQUIPMENT												
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
								%	HRS.			%	HRS.	
1	MAN REW	IND	1.00	PROCESS		H805	1	100	.03					DAVE ZUPAN
1	MAN REW	SPLT.	1.00	SETUP		H805	1	100	.05	PM01H	1	100	.05	HOIST TO TROLE
				PROCESS		H807	1	80	.17	W80001	1	80	.17	
				TRANSIT				20	.42					
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

TO 401-4-203

OPERATION PROFILE

KC-135 Brake - Carrier Assy (Alum)

NAME D. DIVEGESS ALC 0-0 DATE 8 Jun 89 RCC MANAGER SHEET 1 OF 4

WCD 15202N WCD DATE 850400

PCN 15162A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %	
2A	MAN PGW	REM	1.000	TRANSIT							cyl. f sleeves
				SETUP							
				PROCESS			1	100 .25	1	100 .25	
2A	MAN PGW	REM	1.000	TRANSIT							Sm. Pin.
				SETUP							
				PROCESS			1	100 .08	1	100 .08	
2B	MAN PGW	REM	1.000	TRANSIT							Log Pin.
				SETUP			1	100 .03			
				PROCESS			2	100 .17	1	100 .17	
2C	MAN PGW	REM	1.000	TRANSIT							HEAR SHIELD
				SETUP							
				PROCESS			1	100 .03	1	100 .03	
2D	MAN PGW	LOAD	1.000	TRANSIT							O.H. Conveyor
				SETUP							
				PROCESS			1	100 .02	1	100 .02	

TO 461-4-263

OPERATION PROFILE

KC-135 GRABER - CARRIER ASSY (ALUM)

NAME D. DIVELOISS ALC 00 DATE 10 JUN 85 RCC MAN PGM SHEET 2 OF 4

WCD 15202ND1

WCD DATE 89040

PCN
NSN
PM 1516ZA

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	QTY.	%	
32	MAN PGM	CLN	1.00	TRANSIT									CHEM. CLEAN OG 10 ALR. 0626 6634
				SETUP			KI 05	1	100	.00			
				PROCESS	100	2.89							
3A 20	MAN PGM	UNLO	1.00	TRANSIT									FROM O.H. TO ROLLER CONN.
				SETUP									
				PROCESS			KI 05	1	100	.03			
4 20	MAN PGM	Pase	1.00	TRANSIT									BLAST
				SETUP			KI 05	1	100	.03			
				PROCESS			KI 05	1	20 80	.40 .25			
30	MAN PGM	STACK	.05	TRANSIT									ON PALLET
				SETUP									
				PROCESS			KI 05	1	100	.02			
AB 30	OHHO PGM	MOVE	.05	TRANSIT			OV 40	1	100	.00			FROM BLAST TO EDIT
				SETUP									
				PROCESS									

OPERATION PROFILE

KC-135 BRAKE - Carrier Assy (ALUM)

NAME D. DINESS ALC 00 DATE 10 JUN 89 RCC MTANRGW SHEET 3 OF 4

WCD 15202 NDA WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.	
4C 6A	MAN RGW	LOAD	1.000	TRANSIT							TO O.H. CONV. FROM EITHER Pallet or Roller Conv.
				SETUP							
				PROCESS	KIOS	1	100 .03	PM0901	1	100 .03	
ok 6A 6B	MAN RGW	Proc	1.000	TRANSIT							Strip Anodize
				SETUP	KIOS	1	100 .08	PM0901	1	100 .03	
				PROCESS				PM0590	1	100 .03	
6A 6B	MAN RGW	TRAN	1.000	TRANSIT							TO FPI LINE (auto)
				SETUP				PM0901	1	100 .05	
				PROCESS							
200	MAN RGW	UNLO	1.000	TRANSIT							O.H. CONV. TO Roller Conv.
				SETUP				PM0901	1	100 .03	
				PROCESS	KIOS	1	100 .03	PM0903	1	100 .03	
200	MAN RGW	Proc.	1.000	TRANSIT							Nick & Burn
				SETUP	KIOS	1	100 .03				
				PROCESS	KIOS	1	200 .80	PM0410	1	200 .60	
											ACT. PM0411

DR

OPERATION PROFILE

KC-135 BRAKE - CARTRIDGE ASSY

NAME D. DIVELESS ALC 00 DATE 10 JUN 89 RCC MAN PCW SHEET 4 OF 4

WCD 15202000 WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.		
30A 30B	MAN PCW	LOAD	1.000	TRANSIT												TO Roller Conv.
				SETUP												
				PROCESS												
30	MAN PCW	INSO	1.000	TRANSIT												E&I
				SETUP												
				PROCESS												
30A	MAN PCW	STACK	1.000	TRANSIT												To Pallet
				SETUP												
				PROCESS												
30B	MAN PCW	MOVE	1.000	TRANSIT												TO RAD REPAIR
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

OK

OPERATION PROFILE

1K-135 BRAKE - SPACER, BUSHING PLATE - AL

NAME D. DINESS ALC 00 DATE 9 JUN 89 RCC MANPGW SHEET 1 OF 3

WCD		15203 N		WCD DATE		89040									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
					MANDATORY FLOW HOURS %	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		QTY.		TIME REQUIRED			
								%	HRS.			%	HRS.		
2P OK	MAN PGW	LOAD	1.00	TRANSIT								O.H. Conv.			
				SETUP											
				PROCESS		KIOS	1	100	.02	PM0401	1		100	.02	
2AP OK 2PA	MAN PGW DOD	CLN	1.00	TRANSIT								CHEM CLEAN			
				SETUP		KIOS	1	100	.08	PM0401	1		100	3.43	
				PROCESS	100	2.89									ALT. 0626 6634
2AB OK 2AP	MAN PGW	UNLD	1.00	TRANSIT								FROM QH. TO. COLLIER Conv			
				SETUP											
				PROCESS		KIOS	1	100	.03	PM0403	1		100	.03	
2PC OK 2CP	MAN PGW	PROC	1.00	TRANSIT								BIAS			
				SETUP		KIOS	1	100	.03						
				PROCESS		KIOS	1	30	.20	PM0416	1		30	.20	ALT. PM0412
3P	MAN PGW	BRACK	.05	TRANSIT								on Pallet			
				SETUP											
				PROCESS		KIOS	1	70	.25						

* THE REPAIR PROCESS FOR THIS ITEM IS IMPLIED ON MASTER WCD #15202N

15C-20W2C

OPERATION PROFILE

KC-135 BRAKE - SPARE, BACKING PLATE (C)

NAME D. DINEEN ALC 00 DATE 9 JUN 89 RCC MANPGW SHEET 2 OF 3

WCD <u>15Z02N</u>		WCD DATE <u>890400</u>		MANPOWER		EQUIPMENT		TIME REQUIRED		TIME REQUIRED		DATA SOURCE COMMENTS
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	%	MRS.	QTY.	%	
30E 30E	OVHD	MOVE	.05	TRANSIT		OVHD	1	100	.08	FL0002	1	FROM BLAST TO EDM
30F 30F				SETUP								
30G 30G				PROCESS								
6P 6P	MAN PGW	LOAD	1.00	TRANSIT								0.4. Conv From either Pallet or Conveyor
6Q 6Q				SETUP								
6R 6R				PROCESS								Strip Anvate
6S 6S	MAN PGW	PRSC	1.00	TRANSIT		KIOS	1	100	.03	PM0001	1	100 .03
6T 6T				SETUP								
6U 6U				PROCESS								
6V 6V	MAN PGW	TRAN	1.00	TRANSIT								TO FPE LINE
6W 6W				SETUP								
6X 6X				PROCESS								
20P 20P	MAN PGW	UNLD	1.00	TRANSIT								OK. TO Conv. Roller
20Q 20Q				SETUP								
20R 20R				PROCESS								

OPERATION PROFILE

KC-135 BRAKE - SPACER, BACKING PLATE

SHEET 3 OF 3

NAME D. DINGELISS ALC 09 DATE 9 JUN 89 RCC MTAN PGW

WCD DATE 890400

WCD 15202N02

NSN 151620

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
130AP 208P 208P	MTAN PGW	Proc	1.00	TRANSIT							Nick & Burr
				SETUP		1	100 .03				
				PROCESS		1	20 .60 80 .50	PM0410	1	.60 .50	
130AP 208P 208P	MTAN PGW	Load	1.00	TRANSIT							Roller Conv.
				SETUP							
				PROCESS		1	100 .02	Com003	1	100 .02	
130AP 208P 208P	MTAN PGW	Insg.	1.00	TRANSIT							E&I
				SETUP							
				PROCESS		1	40 .05 60 .10				
130AP 208P 208P	MTAN PGW	Stack	1.00	TRANSIT							to Pallet.
				SETUP							
				PROCESS		1	100 .02				
130AP 208P 208P	MTAN PGW	Move	1.00	TRANSIT		1	100 .08	F0003	1	100 .08	From E&I to (RAD Rep)
				SETUP							
				PROCESS							

KC-135 BRAKE - Backing Plate (steel)

SHEET 1 OF 2

WCD DATE 890400[illegible]

1. $\mathcal{L}(\mathcal{M}) \subseteq \mathcal{L}(\mathcal{M}')$

OPERATION PROFILE

KC-135 STRIKE - Bowling PIRATE

NAME D. DIVELEBISS ALC CS DATE 10 JUN 89 RCC MANP6W SHEET 2 OF 2

WCD 15201N		WCD DATE 89040													
MANPOWER		EQUIPMENT													
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
					%	HRS.			%	HRS.			%	HRS.	
200	OV40	MOVE	1.00	TRANSIT			OV40	1	100	.08	FL0003	1	100	.08	MOVE TO E&I
				SETUP											
				PROCESS											
30	MAN REW	Insp	1.00	TRANSIT										E&I	
				SETUP											
				PROCESS											
300	MAN REW	Stack	1.00	TRANSIT			DIS07	1	100	.08	FR0001	1	100	.08	on Pallet
				SETUP											
				PROCESS											
				TRANSIT			DE07	1	100	.02					
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

KC135 BRAKE - STATOR ASSY (steel)

NAME D. D. VIESS ALC 00 DATE 10 JUN 88 RCC MANPSW SHEET 1 OF 2

WCD 15203N		WCD DATE 890Y0												
15162A														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
					%	MRS.	QTY.	%	MRS.	EQUIP. INT CODE		QTY.	%	MRS.
10	MAN PSW	DIS	1.000	TRANSIT								REM. LINES		
				SETUP										
				PROCESS										
10A	MAN PSW	STACK	1.000	TRANSIT								ACT. PM0430 ON PALLET		
				SETUP										
				PROCESS										
10B	MAN PSW	LOAD	1.000	TRANSIT								TO ROTOR BLAST NEAR HOOKS		
				SETUP										
				PROCESS										
20A	MAN PSW	CLN	1.000	TRANSIT								ROTOR BLAST		
				SETUP										
				PROCESS										
20B	MAN PSW	UNLO	1.000	TRANSIT								UNLOAD NEAR HOOKS TO PALLET		
				SETUP										
				PROCESS										

TO 4B1-4-263

1.5C-200020

OPERATION PROFILE

KC-135 BRUE - STATION ASSY

SHEET 2 OF 2

NAME D. DUNEALISS ALC 00 DATE 10 Jun 89 RCC MANPGW

PCN

NSN

PM

15162A

WCD 15203N

WCD DATE 89040

ASH PIN		1562A														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.		
201 17	OVHO Prod	MOVIE	1.00	TRANSIT			OVHO	1	100	0.8		FL00003	1	100	0.8	MOVIE TO SET
				SETUP												
				PROCESS												
30	MAN PGW	Insp	1.00	TRANSIT												EET
				SETUP												
				PROCESS												
30A	MAN PGW	Stack	1.00	TRANSIT			DI07	1	100	0.8		FL00001	1	100	0.8	on Pallet
				SETUP												
				PROCESS												
				TRANSIT			DI07	1	100	0.8						
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

DR

OPERATION PROFILE

KC-135 Brake - Pressure Plate (Steel)

NAME <u>D. DIVELOSS</u> ALC <u>00</u> DATE <u>10 JUN 89</u> RCC <u>MANPGW</u> SHEET <u>1 OF 2</u>		WCD <u>15204N</u> WCD DATE <u>890400</u>												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT			DATA SOURCE COMMENTS		
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE		QTY.	%
10	MAN PGW	DIS	1.00	TRANSIT									MEM LUBES	
				SETUP										
				PROCESS										
10A	MAN PGW	STACK	1.00	TRANSIT									ALT. PTH0430 on Pallet	
				SETUP										
				PROCESS										
10B 2005	MAN PGW	LOAD	1.00	TRANSIT									MEAT HOOKS	
				SETUP										
				PROCESS										
20A 2001	MAN PGW	CLW	1.00	TRANSIT									ROTOR BRST	
				SETUP										
				PROCESS										
20B	MAN PGW	UNLO	1.00	TRANSIT									UNLO - MEAT HOOKS	
				SETUP										
				PROCESS										

OPERATION PROFILE KC-135 BRIDGE - PRESSURE PLATE

NAME D. DINESS ALC 00 DATE 10 JUN 89 RCC MTAN12GW SHEET 2 OF 2

PCN NSN PIN 15162A WCD 152044 WCD DATE 89040														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED % HRS.		
200	0040 1.00	MOVE	1.00	TRANSIT		0V40	1	100	0.08		1	100	0.08	NONE REPT
				SETUP										
				PROCESS										
30	MTAN PGW	INSP	1.00	TRANSIT									E&I	
				SETUP										
				PROCESS		D107	1	100	0.17	FR0001	1	100		0.17
30A	MTAN PGW	STAX	1.00	TRANSIT										
				SETUP										
				PROCESS		D107	1	100	0.02					
				TRANSIT										
				SETUP										
				PROCESS										
				TRANSIT										
				SETUP										
				PROCESS										

WCD 152040 WCD DATE 89040

15162A

OPERATION PROFILE

KC-135 BRAKE - ROTOR SEGMENT ASSY (ST)

NAME D. Dineen ALC 00 DATE 10 JUN 89 RCC MANPCW SHEET 1 OF 2

WCD 15205N WCD DATE 890220

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
1	MAN PGW	Dis-	1.000	TRANSIT											Rem Clips	
				SETUP												
				PROCESS												
1A	MAN PGW	Stack	1.000	TRANSIT			H8005	1	100	.08	W80001	1	100	.08	on Pallet	
				SETUP												
				PROCESS												
1B	OVHO P.W	MOVE	1.000	TRANSIT			H8005	1	100	.02					TO CLEAN	
				SETUP												
				PROCESS												
5	MAN PGW	INSP	1.000	TRANSIT											E & I	
				SETUP												
				PROCESS												
5A	MAN PGW	Stack	1.000	TRANSIT			DI007	1	100	.17					on Pallet	
				SETUP												
				PROCESS												

OPERATION PROFILE

KC-135 Brake - Y200R Segment ASS'Y (Gr)

NAME D. DUESS ALC 00 DATE 10 JUN 89 RCC MTANPGLM SHEET 2 OF 2

WCD 15205N WCD DATE 89070														
15162A														
PM														
NSM														
PC														
P4W														
TO 26AND														
50														
OUMD														
P4W														
MOVE														
1.000														
MANDATORY OCCURRENCE FACTOR														
OPERATION TYPE														
MANDATORY FLOW HOURS														
%														
HRS.														
SKILL CODE/LEVEL														
QTY.														
TIME REQUIRED														
%														
HRS.														
EQUIPMENT CODE														
QTY.														
TIME REQUIRED														
%														
HRS.														
DATA SOURCE COMMENTS														

OPERATION PROFILE

NAME <u>Kertham</u> ALC		DATE		RCC		SHEET <u>1</u> OF <u>3</u>						
WCD <u>15202N</u>		WCD DATE <u>89040</u>		MANPOWER		EQUIPMENT						
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.		EQUIPMENT CODE	QTY.
140	MAN PAP	Imp	1.0	TRANSIT SETUP PROCESS		QHD	1	.01	FL001	1	.01	Inspect palt & check paperwork
150		LOAD	1.0	TRANSIT SETUP PROCESS		VGA9	1	.03	Pm0922	1	.03	LOAD ON paint line
150A		WASH	1.0	TRANSIT SETUP PROCESS		3409	1	.01	Pm0922	1	.01	solvent wash
150B		Plug	1.0	TRANSIT SETUP PROCESS		3409	1	.08	Pm0922	1	.08	Extensive plugging
150C		Prim	1.0	TRANSIT SETUP PROCESS		3409	1	.01	Pm0922	1	.01	Prime & Dry

AC-135 Brake Assy & Housing

OPERATION PROFILE

NAME _____		ALC _____		DATE _____		RCC _____		SHEET <u>2</u> OF <u>3</u>				
WCD <u>15202N</u>		WCD <u>15202A</u>		WCD DATE <u>89040</u>								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	HRS.	QTY.		EQUIPMENT CODE
150D	MAP PG P	Pain	1.0	TRANSIT								1st Load
				SETUP	08	3509	1					
				PROCESS								
150E		Pain	1.0	TRANSIT								2nd Load & Dry
				SETUP	5	3509	1					
				PROCESS								
150F		UNLD	1.0	TRANSIT								UNLOAD and strip
				SETUP								
				PROCESS								
150G		REF	1.0	TRANSIT								Rebuild or repair Piston or Cylinder Assemblies
				SETUP								
				PROCESS								
160		MATCH	1.0	TRANSIT								MATCH UP
				SETUP								
				PROCESS								

KC-135 Brake

OPERATIONAL PROFILE

NAME _____ ALC _____ DATE _____ RCC _____ SHEET 2 OF 2

WCD 1620-2															WCD DATE									
PCN	NSN	PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS								
								%	HRS.	Skill CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.						
80	MAN PRA	Heli	1.00	TRANSIT		JA 09	1	.02							Bench OP									
																SETUP	JA 09	1	.25					
90	MAN PRA	Heli	1.00	TRANSIT		JA 09	1	.02							Bench OP									
																SETUP	JA 09	1	.25					
110	MAN PRA	Repe	.10	TRANSIT		JA 10	1	.02																
																SETUP	JA 10	1	.56	PM 7211	1			.56
115	MAN PRA	Remo	1.00	TRANSIT		JA 10	1	.02																
																SETUP	JA 10	1	.51	PM 5268	1			.51
125	MAN PRA	Inst.	1.00	TRANSIT		JA 09	1	.02							Small Press									
																SETUP	JA 09	1	.19					

KC135 BRACE A
PLANE

OPERATION PROFILE

NAME <u>Norman Fletcher</u> ALC <u>CO-ACC</u> DATE <u>30-MAY-89</u> RCC <u>MANIPGV</u> SHEET <u>1</u> OF <u> </u>													
PCN NSN PIN		WCD <u>15Z02N</u>		WCD DATE <u>09040</u>		EQUIPMENT							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED % HRS.	DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.			EQUIPMENT CODE
118 120	MAN PRC	MOVE	1.0	TRANSIT				1				EXTERNAL MOVE	
				SETUP									
				PROCESS									
119 121	MAN PRC	CLN	1.0	TRANSIT				1				PERUSE T 3M	
				SETUP									
				PROCESS									
120 122	MAN PRC	PEEN PERC	-	TRANSIT				1				SHUT REEN /MASK T 3M	
				SETUP									
				PROCESS									
121 123	MAN PRC	-	-	TRANSIT				1				S/GM P 3M	
				SETUP									
				PROCESS									

OPERATION PROFILE

NAME NICHAN FETTER ALC DCI-ALC DATE 30 MAY 69 RCC MANPGN SHEET 2 OF

PCN NSN PIN		WCD		1520Z N		WCD DATE		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.			%	HRS.	
A 1204	MAN PRC	CLN ANZZ	1.0	TRANSIT			UP05	1			PM 4110	1		.05	TU00
				SETUP			UP09	1			CE20	1		.05	T 3 M
				PROCESS						PM 5001	1		.05	S 3 M	
B 1204	MAN PRC	RINS ANZZ	1.0	TRANSIT											P 507
				SETUP						CE20	1		.05		
				PROCESS			UP09	1			PM 5001	1		.05	
				TRANSIT											RINSE
				SETUP						CE20	1		.01	T/S IM	
				PROCESS			UP09	1			CE20	1		.01	P IM
	-	-	-	TRANSIT							PM 5070	1		.01	
				SETUP											
				PROCESS											
C 1204	MAN PRC	CLN ANZZ	1.0	TRANSIT											Formula PR
				SETUP			UP09	1			CE20	1		.01	T/S IM
				PROCESS			UP09	1			CE20	1		.01	P IM

OPERATION PROFILE

NAME <u>NOIRMAN FELTHER</u> ALC <u>CC-ALC</u> DATE <u>30 MAY 69</u> RCC <u>MANPRAW</u> SHEET <u>3</u> OF <u> </u>														
PCN <u>15202N</u> WCD <u>15202N</u> WCD DATE <u> </u>														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	MANPOWER		EQUIPMENT		TIME REQUIRED %	TIME REQUIRED HRS	DATA SOURCE COMMENTS
					%	HRS		QTY	%	HRS	EQUIPMENT CODE			
-	-	-	-	TRANSIT										
-	-	-	-	SETUP										
-	-	-	-	PROCESS										
D 1205	MAN P/L	RUNS ARE	1.0	TRANSIT										RINSE
-	-	-	-	SETUP			UP09	1						T/S IM
-	-	-	-	PROCESS			UP09	1						P IM
-	-	-	-	TRANSIT										
-	-	-	-	SETUP										
-	-	-	-	PROCESS										
E 1206	MAN P/L	DECK ARE	1.0	TRANSIT										DECK/DEIZE
-	-	-	-	SETUP			UP09	1						T/S IM
-	-	-	-	PROCESS			UP09	1						P 5M 95 IDM 05
-	-	-	-	TRANSIT										
-	-	-	-	SETUP										
-	-	-	-	PROCESS										

OPERATION PROFILE

NAME NORMAN FLETCHER ALC CO-ALC DATE 30 MARCH 79 RCC MANPGW SHEET 4 OF 4

PCN NSN P/N			WCD 1520Z WCD DATE												
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
						SKILL CODE/ LEVEL	QTY.	TIME REQUIRED % HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED % HRS.				
F 120 #	MAN PCC	RINS ANZ2	1.0	TRANSIT									RINSE T/S IM P IM		
				SETUP				UP09	1		.01	CE20		1	.01
				PROCESS				UP09	1		.01	CE20		1	.01
-	-	-	-	TRANSIT											
				SETUP											
				PROCESS											
6 120 #	MAN PCC	ANZ2 ANZ2	1.0	TRANSIT									SULFURIC ANODIZE T/S IM P 45m		
				SETUP				UP09	1		.01	CE20		1	.01
				PROCESS				UP09	1		.05	CE20		1	.05
-	-	-	-	TRANSIT											
				SETUP											
				PROCESS											
4 120 #	MAN PCC	RINS ANZ2	1.0	TRANSIT									RINSE T/S IM P IM		
				SETUP				UP09	1		.01	CE20		1	.01
				PROCESS				UP09	1		.01	CE20		1	.01
PM 5717 1 .75															

OPERATION PROFILE

NAME <u>NOBMAN FLECHER</u> ALC <u>CC</u> ALC DATE <u>30 MAR 69</u> RCC <u>MANP6W</u> SHEET <u>5</u> OF <u>5</u>													
PCN <u>NSH</u> WCD <u>15Z02N</u> WCD DATE <u> </u>													
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
					MANDATORY FLOW HOURS %	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	QTY.	TIME REQUIRED %			
1204 I	MAN PCC	SEAL		TRANSIT								SEAL	
		ANAL		SETUP		UP09	1				1	.01	T/S IM
				PROCESS		UP09	1	95	.05		1	95	.05
1204 J	MAN PCC			TRANSIT									
				SETUP							1	95	.08
				PROCESS								5	.25
1204 K	MAN PCC	RINS		TRANSIT								RINS	
		ANAL		SETUP		UP09	1				1	.01	T/S IM
				PROCESS		UP09	1	.01	.01		1	.01	P IM
1204 L	MAN PCC			TRANSIT									
				SETUP							1	.01	
				PROCESS									
1204 M	MAN PCC	RINS		TRANSIT								RINS, HOT	
		ANAL		SETUP									T/S IM
				PROCESS							1	.01	P IM

OPERATION PROFILE

NAME NURMAN FETTER ALC IG-AUC DATE 30 MAY 69 RCC MANPGW SHEET 62 OF

PCH NSN 15202N WCD 15202N WCD DATE

OPERATION NUMB IN	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.	
1208 MAN PRC	-	DRY WATER	1.0	TRANSIT	-	-	UPG	1	-	01	-	CE20	1	-	01	DEMASK DRY, AIR T IM P ZM
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	UPG	1	-	03	-	CE20	1	-	03	
121 PLA	-	MOVE PLA	1	TRANSIT	-	-	OVHD	1	-	06	-	F000Z	1	-	06	
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	-	-	-	
122 PLA	-	-	-	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	-	-	-	
123 PLA	-	-	-	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	-	-	-	
124 PLA	-	-	-	TRANSIT	-	-	-	-	-	-	-	-	-	-	-	
				SETUP	-	-	-	-	-	-	-	-	-	-	-	
				PROCESS	-	-	-	-	-	-	-	-	-	-	-	

K-135

OPERATIONAL PROFILE

NAME <u>Turner</u> ALC <u>00</u> DATE <u>5-24-89</u> RCC <u>MANPRA</u> SHEET <u>1</u> OF <u>2</u>											
PCN <u>15762 A</u> WCD <u>15202N</u> WCD DATE <u>89040</u>											
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER	EQUIPMENT	TIME REQUIRED	TIME REQUIRED	DATA SOURCE COMMENTS	
					%	QTY.	SKILL CODE/LEVEL	%	HRS.		
32	MAN PRA	Repe	.20	TRANSIT		1	JA 10		.02		
				SETUP		1	JA 10		.56	PM 0757	.56
				PROCESS		1	JA 10		.49	PM 0757	.49
60	MAN PRA	Drill	.60	TRANSIT		1	JA 09		.02		
				SETUP		1	JA 09		.56	PM 2576	.56
				PROCESS		1	JA 09		.49	PM 2576	.49
70	MAN PRA	Drill	.50	TRANSIT		1	JA 09		.02		
				SETUP		1	JA 09		.56	PM 2576	.56
				PROCESS		1	JA 09		.49	PM 2576	.49
72	MAN PRA	Bore	1.00	TRANSIT		1	JA 10		.02		
				SETUP		1	JA 10		.56	PM 5268	.56
				PROCESS		1	JA 10		.29	PM 5268	.29
75	MAN PRA	Repe	.10	TRANSIT		1	JA 10		.02		
				SETUP		1	JA 10		.19	PM 5268	.19
				PROCESS		1	JA 10		1.02	PM 5268	1.02

PCN		NSN 15162A		WBD 150202A		WCD DATE 89040									
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS				
					MANDATORY FLOW HOURS %	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.		TIME REQUIRED %	TIME REQUIRED HRS.		
40	MAN PWS	PRE HEAT	1 1.	TRANSIT								LOAD HEAT UNLOAD			
				SETUP											
				PROCESS	1.0	1.7	WL 10	1	1.0	1.2	GW 21 4191		1	1.0	1.7
40A	MAN PWS	WELD	1 1.	TRANSIT								WELD INLET PORTS			
				SETUP											
				PROCESS							PM 1276		1	1.0	1.0
50	MAN PWS	PRE HEAT	1 1.	TRANSIT								LOAD HEAT UNLOAD			
				SETUP											
				PROCESS	1.0	1.7	WL 10	1	1.0	1.2	GW 21 4191		1	1.0	1.7
50A	MAN PWS	WELD	1 1.	TRANSIT								WELD CRACKS PIPGS			
				SETUP											
				PROCESS							PM 1276		1	1.0	1.0
50B	MAN PWS	POST HEAT	1 1.	TRANSIT								Post HEAT			
				SETUP											
				PROCESS	1.0	1.7	WL 10	1	1.0	1.2	GW 21 4191		1	1.0	1.7

OPERATION PROFILE

NAME <u>MEL ANDERSON</u> ALC <u>00</u> DATE <u>5-31-89</u> RCC <u>MANPGW</u> SHEET <u>1</u> OF <u>2</u>		WCD <u>15303N</u> WCD DATE <u>89040</u>											
CON NSN P/N <u>15162A</u>		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS							
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED	
								%	HRS.			%	HRS.
				TRANSIT									
		SETUP											
		PROCESS											
10	MAN PGW	Load	1.0	TRANSIT		OVHD	1			FL 0002	1		.02
				TRANSIT									
				PROCESS		KI07	1			PM 0901	1		.05
10A	MAN PNA	FPI	.25	TRANSIT						PM 0901	1		.02
				PROCESS						PM 0901	1		1.10
				PROCESS		DB09	1			PM 0679E	1		1.10
10B	MAN PNA	FPI	.75	TRANSIT						PM 0901	1		.02
				PROCESS						PM 0901	1		1.05
				PROCESS		DB09	2			PM 0679E	1		1.05
10C	MAN PGW	Unld	1.0	TRANSIT						PM 0901	1		.05
				PROCESS									
				PROCESS		KI07	1			PM 0901	1		.05

15303N
F. 15303N

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 2 OF 2

WCD 15203N WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.			%	HRS.			%	HRS.		
34	MAN PGW	LOAD	.20	TRANSIT												
				SETUP												
				PROCESS												
34A	MAN PNA	FPI	.05	TRANSIT												
				PROCESS												1.10
				PROCESS												1.10
34B	MAN PNA	FPI	.15	TRANSIT												
				PROCESS												
				PROCESS												
34C	MAN PGW	UNLD	.20	TRANSIT												
				PROCESS												
				PROCESS												

OPERATION PROFILE

NAME <u>Kyle</u>		ALC		DATE		RCC		SHEET <u>3</u> OF <u>3</u>				
WCD <u>15202N</u>		WCD DATE <u>89040</u>		WCD DATE <u>89040</u>		WCD DATE <u>89040</u>		WCD DATE <u>89040</u>				
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
						SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.		EQUIPMENT CODE	QTY.
170	MAN P P	ASM	1.0	TRANSIT SETUP PROCESS		Y609	1	1.8	WA005	1	1.8	Assembly
180		Test	1.0	TRANSIT SETUP PROCESS		Y609	1	.25	PM0449	1	.25	Test & Details
205 200		Asst Insp	1.0	TRANSIT SETUP PROCESS		Y609	1	.05	PM0933	1	.05	Final Insp Paper check Etc.
220		Insp	1.0	TRANSIT SETUP PROCESS		Y609	1	.05	PM0933	1	.05	Final Insp

KC-135 Brake ASM

1333

SHEET ___ OF ___

WCD DATE 89040

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162A

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OPERATIONAL PROFILE

NAME Turner ALC 00 DATE 5-24-89 RCC MANPRA SHEET 1 OF 1

PCN NSN P/N		WCD <u>15203N</u>		WCD DATE <u>88040</u>		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS	
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		QTY.	EQUIPMENT CODE	TIME REQUIRED HRS.
					%	HRS.			%	HRS.			
60	MAN	Radi.	1.00	TRANSIT			JA 10	1					
	SETUP								PM 1788	1			.24
	PROCESS								PM 1788	1			.13
75	MAN	Rezm	1.00	TRANSIT			JA 10	1					
	SETUP								PM 1788	1			.24
	PROCESS								PM 1788	1			.17
				TRANSIT									
	SETUP												
	PROCESS												
				TRANSIT									
	SETUP												
	PROCESS												
				TRANSIT									
	SETUP												
	PROCESS												

OPERATION PROFILE

NAME <u>MEL ANDERSON</u> ALC <u>00</u> DATE <u>5-31-89</u> RCC <u>MANPGW</u> SHEET <u>1</u> OF <u>1</u>											
WCD <u>15203A</u>		WCD <u>15203A</u>		WCD DATE <u>89040</u>		EQUIPMENT					
15162A		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS % HRS.	SKILL CODE/LEVEL	QTY.	TIME REQUIRED % HRS.	QTY.	TIME REQUIRED % HRS.	
				TRANSIT							
				SETUP							
				PROCESS							
80	MAN PNA	MAG	1.0	TRANSIT		OVHD	1	.02	FL 0002	1	.02
				PROCESS		DB09	1	.10	PM 6668	1	.10
80A	MAN PNA	DEGR	1.0								
				PROCESS		DB09	1	.07	PM 3428	1	.07
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

OPERATION PROFILE

NAME KEITHAN ALC _____ DATE _____ RCC BRakes SHEET 1 OF 2

WCD 15203N WCD DATE 890410

NSN 15162A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%
90	MAN PAP	LOAD	1.0	TRANSIT									LOAD Paint Line	
				SETUP										
				PROCESS			3509	1		.01	Pm0922	1		.01
90A		Prim	1.0	TRANSIT									Prime & Dry	
				SETUP		.26	5509	1		.01	Pm0922	1		.26
				PROCESS							Pm0928	1		.01
90B		UNLD	1.0	TRANSIT									UNLOAD	
				SETUP			4609	1		.01	Pm0922	1		.01
				PROCESS							Pm0928	1		.01
95		INCP	1.0	TRANSIT									Flatness Inspection	
				SETUP										
				PROCESS			4609	1		.02	IT001	1		.02
100		Rivet	1.0	TRANSIT									Rivet friction pads	
				SETUP										
				PROCESS										

KC-135 Stator

OPERATION PROFILE

NAME <u>KEESHAN</u>		ALC		DATE		RCC <u>MANAGER Biales</u>		SHEET <u>2</u> OF <u>2</u>					
PCN		NSN		WCD <u>15162A</u>		WCD <u>15103N</u>		WCD DATE <u>89040</u>					
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS		
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED			
					%	HRS.		%	HRS.		%	HRS.	
120	P&P	Aspt	1.0	TRANSIT								Accept paper work	
				SETUP									
				PROCESS									
130	P&P	Insp	1.0	TRANSIT								Final Used Insp	
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									
				TRANSIT									
				SETUP									
				PROCESS									

•

NAME C. J. 22 FOR 13 ALG 00 DATE 5-30-89 RCC MANI P. W. U. SHEET OF

WCD 15204 N WCD DATE 89040

WCO 152042

PCN

PCN

[illegible]

150.24412.

OPERATION PROFILE

NAME Turner ALC 50 DATE 5-24-89 RCC MANPRA SHEET 1 OF 1

PCN 15162A WCD 15204N

WCD DATE 89040

MSN PM

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED %	QTY.	
50	MAN	Repe	.90.	TRANSIT		JA09	1				
	RA			SETUP		JA09	1			1	
				PROCESS		JA09	1			1	
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

WCD 15204N WCD DATE 89040

PCN
NSN
PM
15162A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
70	MAN PNA	MAG	1.0	TRANSIT		1	.02	FL 0002	1	.02	
				PROCESS		1	.10	PM 6668	1	.10	
				PROCESS		1	.07	PM 3428	1	.07	
70A	MAN PNA	DEGR	1.0	TRANSIT							
				SETUP							
				PROCESS							
				TRANSIT							
				SETUP							
				PROCESS							

OPERATION PROFILE

NAME KERSHAW ALC _____ DATE _____ RCC _____ SHEET 1 OF 2

WCD 1520H N WCD DATE 89040

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS
					MANDATORY FLOW HOURS	QTY.	TIME REQUIRED	EQUIPMENT CODE	QTY.	TIME REQUIRED	
					%		%			%	
80	MAN PAP	LOAD	1.0	TRANSIT							
				SETUP							
				PROCESS							
80A		Prin	1.0	TRANSIT							
				SETUP	1	1	.01	Pm0922	1		Prin to Dry
				PROCESS				Pm0433	1	.01	
80B		Prin	1.0	TRANSIT							
				SETUP	.08	1	.01	Pm0922	1	.08	1st Coat one side
				PROCESS				Pm0436	1	.01	
80C		Prin	1.0	TRANSIT							
				SETUP	.5	1	.01	Pm0922	1	.5	2nd Coat one side & Dry
				PROCESS				Pm0436	1	.01	
80D		UNLD	1.0	TRANSIT							
				SETUP		1	.01	Pm0922	1	.01	UNLOAD
				PROCESS				Pm0433	1	.01	

KC-135 Pressure plate

OPERATION PROFILE

NAME <u>KEVIN</u> ALC <u>DATE</u> <u>15/02/10</u> RCC <u>2</u> OF <u>2</u>		WCD <u>15/02/10</u> WCD DATE <u>09/04/10</u>		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS			
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.
85	MAN PEP	INSP	1.0	TRANSIT									
				SETUP									
				PROCESS		Y609	1		.02	I10001	1		.02
90		Rivet	1.0	TRANSIT									
				SETUP									
				PROCESS		Y609	1		.08	Rm 7384	1		.08
100		ACP	1.0	TRANSIT									
				SETUP									
				PROCESS		Y609	1		.02				
110		INSP	1.0	TRANSIT									
				SETUP									
				PROCESS		Y609	1		.02				
				TRANSIT									
				SETUP									
				PROCESS									

MC-135 Pressure Plate

OPERA PROFILE

NAME Turner ALC 60 DATE 5-24-89 RCC MAN PRD SHEET 1 OF 1

PCN 15162A WCD 15205N WCD DATE 89040

PIN		131624														
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS	
					%	HRS.	SKILL CODE/LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.		
10	MAN	Grin	1.0	TRANSIT			JAO9	1		.02						
	SETUP					JAO9	1		.25	PM 6654	1		.25			
	PROCESS					JAO9	1		.25	PM 6654	1		.25			
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												
				TRANSIT												
				SETUP												
				PROCESS												

OPERATION PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

WCD 15205N WCD DATE 89010																	
OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS			MANPOWER			EQUIPMENT			DATA SOURCE COMMENTS			
					%	HRS.		QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%		HRS.		
				TRANSIT											FMPI		
				SETUP													
				PROCESS													
20	MAN PNA	MAG	1.0	TRANSIT			OVHD	1		.02	FL 0003	1		.02			
				PROCESS			DB09	1		.10	PM 6668	1		.10			
30	MAN PNA	DEMO	1.0												DEMAG		
				PROCESS			DB09	1		.04	PM 7293	1		.04			
30A	MAN PNA	DECR	1.0												DECREASE		
				PROCESS			DB09	1		.07	PM 3428	1		.07			
				TRANSIT													
				SETUP													
				PROCESS													

File

OPERATION PROFILE

NAME Verhagen ALC _____ DATE _____ RCC _____ Broken SHEET 1 OF _____

WCD 15205N WCD DATE 09040

PM 12/26/21	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		TIME REQUIRED		DATA SOURCE COMMENTS		
						%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.
40	MAN Prep	✓	bip	1.0	TRANSIT									Dip in oil and hold for drain		
					SETUP		.5	Y609	1		.02	DT0001	1			.02
					PROCESS							DT0001	1			.5
090		✓	Acp	1.0	TRANSIT									paperwork		
					SETUP											
					PROCESS			Y609	1		.02					
060		✓	Insp	1.0	TRANSIT									Final Visual Insp		
					SETUP											
					PROCESS			Y609	1		.02					
					TRANSIT											
					SETUP											
					PROCESS											
					TRANSIT											
					SETUP											
					PROCESS											

NC-135 Refor

OPERATION PROFILE

KC-135

STEEL

NAME C. GREEN FORB ALB 00 DATE 5-30-89 RCC MAN POW WCD DATE 89040 SHEET 0F

WCD 15201A WCD 89040

PM 15162A

NSN PIN	OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/ LEVEL	MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS		
						%	HRS.		QTY.	%	TIME REQUIRED HRS.	QTY.		%	TIME REQUIRED HRS.
40	MAN POW	LOAD	1	TRANSIT									Load on rack & Place in Furnace 10/ stack 20/LOAD		
				SETUP											
				PROCESS											
40A	MAN POW	Bake	1	TRANSIT									HEAT UP IN OVEN		
				SETUP											
				PROCESS											
40B	MAN POW	UNLOAD	1	TRANSIT									REMOVE FROM OVEN		
				SETUP											
				PROCESS											
40C	MAN POW	COOL DOWN		TRANSIT									AIR COOL DOWN		
				SETUP											
				PROCESS	1.0	6.0									
40D	MAN POW	UNLOAD		TRANSIT									REMOVE FROM RACK BY HAND		
				SETUP											
				PROCESS											

Load on Rack + Place in Furnace 10/STACK 20/LOAD

HEAT UP IN OVEN

REMOVE FROM OVEN

AIR COOL DOWN

REMOVE FROM RACK BY HAND

150-200000

OPERATIONAL PROFILE

NAME MEL ANDERSON ALC 00 DATE 5-31-89 RCC MANPGW SHEET 1 OF 1

PCD
HSH
PM

15162A

WCD 15201N

WCD DATE 89040

15162A

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		SKILL CODE/LEVEL	QTY.	TIME REQUIRED		EQUIPMENT		DATA SOURCE COMMENTS			
					%	HRS.			%	HRS.	EQUIPMENT CODE	QTY.		%	HRS.	
SS	MAN PNA	MAG	1.0	TRANSIT			OVHD	1		.02	FL 0002	1		.02		
				PROCESS			DB09	1		.10	PM 6668	1		.10		
				PROCESS												
SSA	MAN PNA	DEGR	1.0	TRANSIT												
				PROCESS			DB09	1		.07	PM 3428	1		.07		
				PROCESS												
				TRANSIT												
				SETUP												
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OPERATING PROFILE

NAME KEVIN ALC 00 DATE 5-31-89 RCC Bridges SHEET 1 OF 2

WCD 15201N WCD DATE 89010

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANPOWER			EQUIPMENT			TIME REQUIRED		DATA SOURCE COMMENTS
					SKILL CODE/LEVEL	QTY.	%	TIME REQUIRED	EQUIPMENT CODE	QTY.	%	HRS.	
70	MAN PGP	LOAD	1.0	TRANSIT									LOAD M Paint line
				SETUP									
				PROCESS	3409	1		.01	PM0922	1		.01	
70A		Prim	1.0	TRANSIT									Prime & Dry both sides
				SETUP	3409	1		.01	PM0922	1		1	
				PROCESS					PM0438	1		.01	
70B		Prim	1.0	TRANSIT									pt coat one side
				SETUP	3409	1		.01	PM0922	1		.01	
				PROCESS					PM0436	1		.01	
70C		Prim	1.0	TRANSIT									2nd coat & Dry
				SETUP	3409	1		.01	PM0922	1		.5	
				PROCESS					PM0437	1		.01	
70D		UNLD	1.0	TRANSIT									UNLOAD
				SETUP	4409	1		.01	PM0922	1		.01	
				PROCESS					PM0928	1		.01	

KE-135 Backing plate

OPERATION PROFILE

NAME _____ ALC _____ DATE _____		RCC _____		SHEET <u>2</u> OF <u>2</u>								
WCD <u>15201A</u>		WCD DATE <u>09040</u>										
PIN <u>151621A</u>		MANPOWER		EQUIPMENT								
OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS	SKILL CODE/LEVEL	TIME REQUIRED		QTY.	TIME REQUIRED		DATA SOURCE COMMENTS
							%	HRS.		%	HRS.	
75	MPM RIP	JWR	1.0	TRANSIT								Check plate cleanliness
				SETUP								
				PROCESS								
80		RWT	1.0	TRANSIT								Install (Rust) wear pads
				SETUP								
				PROCESS								
85		ACPT	1.0	TRANSIT								Acceptance of paperwork
				SETUP								
				PROCESS								
100		JWR	1.0	TRANSIT								Final visual Insp
				SETUP								
				PROCESS								
				TRANSIT								
				SETUP								
				PROCESS								

AC-135 backing plate.

OPERATION PROFILE

NAME KE-135 ALC 1562A DATE 15202 RCC MAN P&P - Brakes SHEET 1 OF 1

WCD P15203		WCD DATE 89208																	
WCD 15162-A		WCD 89208																	
NSN P/N		NSN P/N																	
OPERATION NUMBER		RCC		OPERATION DESCRIPTION		MANDATORY OCCURRENCE FACTOR		OPERATION TYPE		MANDATORY FLOW HOURS		MANPOWER		EQUIPMENT		DATA SOURCE COMMENTS			
010A		MAN P&P		Dis		1.0		TRANSIT		%		QTY.		TIME REQUIRED %		HRS.		DISASSEMBLE	
								SETUP											
								PROCESS				1				.03			
								TRANSIT				1				.01			
								SETUP											
								PROCESS				1				.08			
								TRANSIT								.50			
								SETUP											
								PROCESS											

KE-135 Brake cylinder and return spring assemblies
 penedo WCD # P 15202
 Note: Bear Brake Assy